



**OM-1582**

138 593X

September 2001

**Processes**



MIG (GMAW)  
Flux Cored (FCAW)  
(Gas- and Self-Shielded)  
Submerged (SAW)

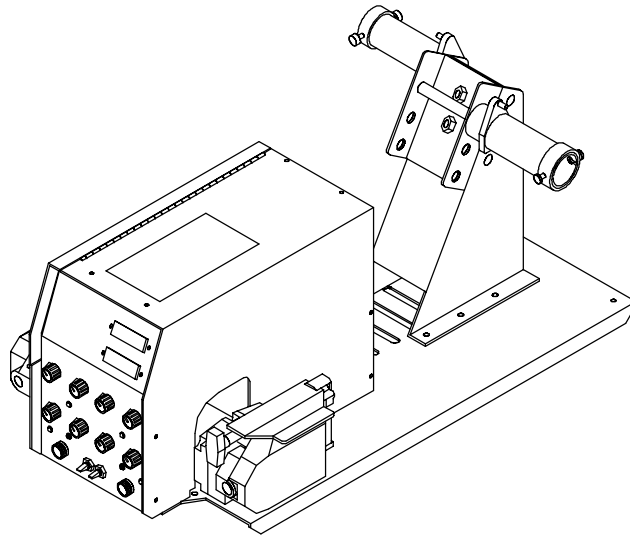
**Description**



Wire Feeder  
(Use with CV Power Sources)

CE

# D-64



Visit our website at  
[www.MillerWelds.com](http://www.MillerWelds.com)

## OWNER'S MANUAL

# From Miller to You

*Thank you and congratulations* on choosing Miller. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

That's why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn't afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.



Today, the people that build and sell Miller products continue the tradition. They're just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

This Owner's Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite. We've



Miller is the first welding equipment manufacturer in the U.S.A. to be registered to the ISO 9001 Quality System Standard.

made installation and operation quick and easy. With Miller you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide which exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.

Miller Electric manufactures a full line of welders and welding related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual catalog sheets. **To locate your nearest distributor or service agency call 1-800-4-A-Miller, or visit us at [www.MillerWelds.com](http://www.MillerWelds.com) on the web.**



Working as hard as you do – every power source from Miller is backed by the most hassle-free warranty in the business.

*Miller offers a Technical Manual which provides more detailed service and parts information for your unit. To obtain a Technical Manual, contact your local distributor. Your distributor can also supply you with Welding Process Manuals such as SMAW, GTAW, GMAW, and GMAW-P.*




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## **WARNING**

This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)

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<b>WARRANTY</b>	

# Declaration of Conformity for European Community (CE) Products

**Note**  This information is provided for units with CE certification (see rating label on unit).

*Manufacturer's Name:* **Miller Electric Mfg. Co.**

*Manufacturer's Address:* 1635 W. Spencer Street  
Appleton, WI 54914 USA

*Declares that the product:* **D-64**

*conforms to the following Directives and Standards:*

## Directives

Low Voltage Directive: 73/23/EEC

Electromagnetic Compatibility (EMC) Directive: 89/336/EEC

Machinery Directives: 89/392/EEC, 91/368/EEC, 93/C 133/04, 93/68/EEC

## Standards

Arc Welding Equipment Part I: Welding Power Sources: IEC 60974-1  
(September 1998 – Second Edition)

Arc Welding Equipment: Wirefeed Systems: IEC 974-5  
(September 1997 – Draft Revision)

Degrees of Protection Provided By Enclosures (IP Code): IEC 529  
(November 1989 – First Edition)

Insulation Coordination For Equipment With Low-Voltage Systems:  
Part I: Principles, Requirements and Tests: IEC 664-1  
(October 1992 – First Edition)

Electromagnetic Compatibility, (EMC): EN 50199  
(August 1995)

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# SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

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## 1-1. Symbol Usage



Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.

▲ Marks a special safety message.

☞ Means "Note"; not safety related.



This group of symbols means Warning! Watch Out! possible ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

## 1-2. Arc Welding Hazards

▲ The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-4. Read and follow all Safety Standards.

▲ Only qualified persons should install, operate, maintain, and repair this unit.

▲ During operation, keep everybody, especially children, away.



### ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also

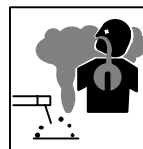
live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first – double-check connections.
- Frequently inspect input power cord for damage or bare wiring – replace cord immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.

- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

### SIGNIFICANT DC VOLTAGE exists after removal of input power on inverters.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.



### FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
- If ventilation is poor, use an approved air-supplied respirator.
- Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instructions for metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.



### ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear a welding helmet fitted with a proper shade of filter to protect your face and eyes when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather and wool) and foot protection.



### WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Protect yourself and others from flying sparks and hot metal.
- Do not weld where flying sparks can strike flammable material.
- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.



### FLYING METAL can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



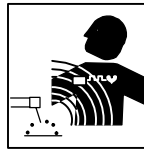
### BUILDUP OF GAS can injure or kill.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



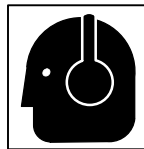
### HOT PARTS can cause severe burns.

- Do not touch hot parts bare handed.
- Allow cooling period before working on gun or torch.



### MAGNETIC FIELDS can affect pacemakers.

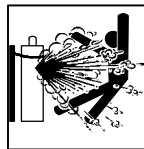
- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near arc welding, gouging, or spot welding operations.



### NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



### CYLINDERS can explode if damaged.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.

## 1-3. Additional Symbols For Installation, Operation, And Maintenance



### FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.



### MOVING PARTS can cause injury.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.



### FALLING UNIT can cause injury.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.



### OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



### STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



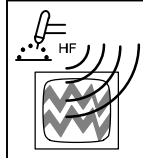
### MOVING PARTS can cause injury.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



### WELDING WIRE can cause injury.

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.



### H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



### ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

## 1-4. Principal Safety Standards

*Safety in Welding and Cutting*, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd, Miami FL 33126

*Safety and Health Standards*, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

*Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances*, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd, Miami, FL 33126

*National Electrical Code*, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

*Safe Handling of Compressed Gases in Cylinders*, CGA Pamphlet P-1, from Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

*Code for Safety in Welding and Cutting*, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

*Safe Practices For Occupation And Educational Eye And Face Protection*, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

*Cutting And Welding Processes*, NFPA Standard 51B, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

## 1-5. EMF Information

### Considerations About Welding And The Effects Of Low Frequency Electric And Magnetic Fields

Welding current, as it flows through welding cables, will cause electromagnetic fields. There has been and still is some concern about such fields. However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: "The body of evidence, in the committee's judgment, has not demonstrated that exposure to power-frequency electric and magnetic fields is a human-health hazard." However, studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

To reduce magnetic fields in the workplace, use the following procedures:

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.
4. Keep welding power source and cables as far away from operator as practical.
5. Connect work clamp to workpiece as close to the weld as possible.

#### **About Pacemakers:**

Pacemaker wearers consult your doctor first. If cleared by your doctor, then following the above procedures is recommended.



# SECTION 1 – CONSIGNES DE SECURITE – LIRE AVANT UTILISATION

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## 1-1. Signification des symboles



Signifie Mise en garde ! Soyez vigilant ! Cette procédure présente des risques de danger ! Ceux-ci sont identifiés par des symboles adjacents aux directives.

### ▲ Identifie un message de sécurité particulier.

Signifie NOTA ; n'est pas relatif à la sécurité.



Ce groupe de symboles signifie Mise en garde ! Soyez vigilant ! Il y a des risques de danger reliés aux CHOCS ÉLECTRIQUES, aux PIÈCES EN MOUVEMENT et aux PIÈCES CHAUDES. Reportez-vous aux symboles et aux directives ci-dessous afin de connaître les mesures à prendre pour éviter tout danger.

## 1-2. Dangers relatifs au soudage à l'arc

▲ Les symboles présentés ci-après sont utilisés tout au long du présent manuel pour attirer votre attention et identifier les risques de danger. Lorsque vous voyez un symbole, soyez vigilant et suivez les directives mentionnées afin d'éviter tout danger. Les consignes de sécurité présentées ci-après ne font que résumer l'information contenue dans les normes de sécurité énumérées à la section 1-4. Veuillez lire et respecter toutes ces normes de sécurité.

▲ L'installation, l'utilisation, l'entretien et les réparations ne doivent être confiés qu'à des personnes qualifiées.

▲ Au cours de l'utilisation, tenir toute personne à l'écart et plus particulièrement les enfants.



### UN CHOC ÉLECTRIQUE peut tuer.

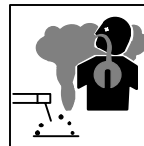
Un simple contact avec des pièces électriques peut provoquer une électrocution ou des blessures graves. L'électrode et le circuit de soudage sont sous tension dès que l'appareil est sur ON. Le circuit d'entrée et les circuits internes de l'appareil sont également sous tension à ce moment-là. En soudage semi-automatique ou automatique, le fil, le dévidoir, le logement des galets d'entraînement et les pièces métalliques en contact avec le fil de soudage sont sous tension. Des matériels mal installés ou mal mis à la terre présentent un danger.

- Ne jamais toucher les pièces électriques sous tension.
- Porter des gants et des vêtements de protection secs ne comportant pas de trous.
- S'isoler de la pièce et de la terre au moyen de tapis ou d'autres moyens isolants suffisamment grands pour empêcher le contact physique éventuel avec la pièce ou la terre.
- Ne pas se servir de source électrique à courant électrique dans les zones humides, dans les endroits confinés ou là où on risque de tomber.
- Se servir d'une source électrique à courant électrique UNIQUEMENT si le procédé de soudage le demande.
- Si l'utilisation d'une source électrique à courant électrique s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.
- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Installer et mettre à la terre correctement cet appareil conformément à son manuel d'utilisation et aux codes nationaux, provinciaux et municipaux.
- Toujours vérifier la terre du cordon d'alimentation – Vérifier et s'assurer que le fil de terre du cordon d'alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- En effectuant les raccordements d'entrée fixer d'abord le conducteur de mise à la terre approprié et contre-vérifier les connexions.
- Vérifier fréquemment le cordon d'alimentation pour voir s'il n'est pas endommagé ou dénudé – remplacer le cordon immédiatement s'il est endommagé – un câble dénudé peut provoquer une électrocution.
- Mettre l'appareil hors tension quand on ne l'utilise pas.
- Ne pas utiliser des câbles usés, endommagés, de grosseur insuffisante ou mal épissés.
- Ne pas enrouler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode provenant d'une autre machine.

- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretien l'appareil conformément à ce manuel.
- Porter un harnais de sécurité quand on travaille en hauteur.
- Maintenir solidement en place tous les panneaux et capots.
- Fixer le câble de retour de façon à obtenir un bon contact métal-métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Isoler la pince de masse quand pas mis à la pièce pour éviter le contact avec tout objet métallique.

## Il y a DU COURANT CONTINU IMPORTANT dans les convertisseurs après la suppression de l'alimentation électrique.

- Arrêter les convertisseurs, débrancher le courant électrique, et décharger les condensateurs d'alimentation selon les instructions indiquées dans la partie entretien avant de toucher les pièces.



### LES FUMÉES ET LES GAZ peuvent être dangereux.

Le soudage génère des fumées et des gaz. Leur inhalation peut être dangereuse pour votre santé.

- Eloigner votre tête des fumées. Ne pas respirer les fumées.
- A l'intérieur, ventiler la zone et/ou utiliser un échappement au niveau de l'arc pour l'évacuation des fumées et des gaz de soudage.
- Si la ventilation est insuffisante, utiliser un respirateur à alimentation d'air homologué.
- Lire les spécifications de sécurité des matériaux (MSDSs) et les instructions du fabricant concernant les métaux, les consommables, les revêtements, les nettoyants et les dégraissants.
- Travailler dans un espace fermé seulement s'il est bien ventilé ou en portant un respirateur à alimentation d'air. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz de soudage peuvent déplacer l'air et abaisser le niveau d'oxygène provoquant des blessures ou des accidents mortels. S'assurer que l'air de respiration ne présente aucun danger.
- Ne pas souder dans des endroits situés à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur et des rayons de l'arc peuvent réagir en présence de vapeurs et former des gaz hautement toxiques et irritants.
- Ne pas souder des métaux munis d'un revêtement, tels que l'acier galvanisé, plaqué en plomb ou au cadmium à moins que le revêtement n'ait été enlevé dans la zone de soudure, que l'endroit soit bien ventilé, et si nécessaire, en portant un respirateur à alimentation d'air. Les revêtements et tous les métaux renfermant ces éléments peuvent dégager des fumées toxiques en cas de soudage.



## LES RAYONS DE L'ARC peuvent provoquer des brûlures dans les yeux et sur la peau.

Le rayonnement de l'arc du procédé de soudage génère des rayons visibles et invisibles intenses (ultraviolets et infrarouges) susceptibles de provoquer des brûlures dans les yeux et sur la peau. Des étincelles sont projetées pendant le soudage.

- Porter un casque de soudage muni d'un écran de filtre approprié pour protéger votre visage et vos yeux pendant le soudage ou pour regarder (voir ANSI Z49.1 et Z87.1 énuméré dans les normes de sécurité).
- Porter des protections approuvés pour les oreilles si le niveau sonore est trop élevé.
- Utiliser des écrans ou des barrières pour protéger des tiers de l'éclair et de l'éblouissement; demander aux autres personnes de ne pas regarder l'arc.
- Porter des vêtements de protection constitué dans une matière durable, résistant au feu (cuir ou laine) et une protection des pieds.



## LE SOUDAGE peut provoquer un incendie ou une explosion.

Le soudage effectué sur des conteneurs fermés tels que des réservoirs, tambours ou des conduites peut provoquer leur éclatement. Des étincelles peuvent être projetées de l'arc de soudure. La projection d'étincelles, des pièces chaudes et des équipements chauds peut provoquer des incendies et des brûlures. Le contact accidentel de l'électrode avec des objets métalliques peut provoquer des étincelles, une explosion, un surchauffement ou un incendie. Avant de commencer le soudage, vérifier et s'assurer que l'endroit ne présente pas de danger.

- Se protéger et d'autres personnes de la projection d'étincelles et de métal chaud.
- Ne pas souder dans un endroit là où des étincelles peuvent tomber sur des substances inflammables.
- Déplacer toutes les substances inflammables à une distance de 10,7 m de l'arc de soudage. En cas d'impossibilité les recouvrir soigneusement avec des protections homologués.
- Des étincelles et des matériaux chauds du soudage peuvent facilement passer dans d'autres zones en traversant de petites fissures et des ouvertures.
- Surveiller tout déclenchement d'incendie et tenir un extincteur à proximité.
- Le soudage effectué sur un plafond, plancher, paroi ou séparation peut déclencher un incendie de l'autre côté.
- Ne pas effectuer le soudage sur des conteneurs fermés tels que des réservoirs, tambours, ou conduites, à moins qu'ils n'aient été préparés correctement conformément à AWS F4.1 (voir les normes de sécurité).
- Brancher le câble sur la pièce le plus près possible de la zone de soudage pour éviter le transport du courant sur une longue distance par des chemins inconnus éventuels en provoquant des risques d'électrocution et d'incendie.
- Ne pas utiliser le poste de soudage pour dégeler des conduites gelées.
- En cas de non utilisation, enlever la baguette d'électrode du porte-électrode ou couper le fil à la pointe de contact.
- Porter des vêtements de protection dépourvus d'huile tels que des gants en cuir, une chemise en matériau lourd, des pantalons sans revers, des chaussures hautes et un couvre chef.
- Avant de souder, retirer toute substance combustible de vos poches telles qu'un allumeur au butane ou des allumettes.



## DES PARTICULES VOLANTES peuvent blesser les yeux.

- Le soudage, l'écaillage, le passage de la pièce à la brosse en fil de fer, et le meulage génèrent des étincelles et des particules métalliques volantes. Pendant la période de refroidissement des soudures, elles risquent de projeter du laitier.
- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.



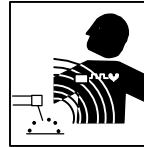
## LES ACCUMULATIONS DE GAZ risquent de provoquer des blessures ou même la mort.

- Fermer l'alimentation du gaz protecteur en cas de non utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.



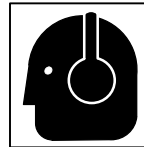
## DES PIÈCES CHAUDES peuvent provoquer des brûlures graves.

- Ne pas toucher des parties chaudes à mains nues
- Prévoir une période de refroidissement avant d'utiliser le pistolet ou la torche.



## LES CHAMPS MAGNÉTIQUES peuvent affecter les stimulateurs cardiaques.

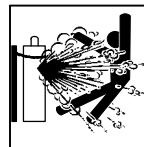
- Porteurs de stimulateur cardiaque, restez à distance.
- Les porteurs d'un stimulateur cardiaque doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de gougeage ou de soudage par points.



## LE BRUIT peut affecter l'ouïe.

Le bruit des processus et des équipements peut affecter l'ouïe.

- Porter des protections approuvés pour les oreilles si le niveau sonore est trop élevé.



## Si des BOUTEILLES sont endommagées, elles pourront exploser.

Des bouteilles de gaz protecteur contiennent du gaz sous haute pression. Si une bouteille est endommagée, elle peut exploser. Du fait que les bouteilles de gaz font normalement partie du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, du laitier, des flammes ouvertes, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber ou de se renverser.
- Tenir les bouteilles éloignées des circuits de soudage ou autres circuits électriques.
- Ne jamais placer une torche de soudage sur une bouteille à gaz.
- Une électrode de soudage ne doit jamais entrer en contact avec une bouteille.
- Ne jamais souder une bouteille pressurisée – risque d'explosion.
- Utiliser seulement des bouteilles de gaz protecteur, régulateurs, tuyaux et raccords convenables pour cette application spécifique; les maintenir ainsi que les éléments associés en bon état.
- Ne pas tenir la tête en face de la sortie en ouvrant la soupape de la bouteille.
- Maintenir le chapeau de protection sur la soupape, sauf en cas d'utilisation ou de branchement de la bouteille.
- Lire et suivre les instructions concernant les bouteilles de gaz comprimé, les équipements associés et les publications P-1 CGA énumérées dans les normes de sécurité.

## 1-3. Dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance



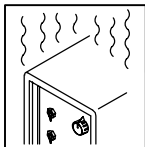
### Risque D'INCENDIE OU D'EXPLOSION.

- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
- Ne pas installer l'appareil à proximité de produits inflammables
- Ne pas surcharger l'installation électrique – s'assurer que l'alimentation est correctement dimensionnée et protégée avant de mettre l'appareil en service.



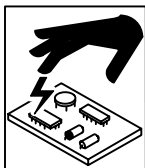
### LA CHUTE DE L'APPAREIL peut blesser.

- Utiliser l'anneau de levage uniquement pour soulever l'appareil, NON PAS les chariot, les bouteilles de gaz ou tout autre accessoire.
- Utiliser un engin d'une capacité appropriée pour soulever l'appareil.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.



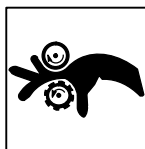
### L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Prévoir une période de refroidissement, respecter le cycle opératoire nominal.
- Réduire le courant ou le cycle opératoire avant de recommencer le soudage.
- Ne pas obstruer les passages d'air du poste.



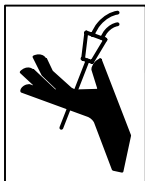
### LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Établir la connexion avec la barrette de terre avant de manipuler des cartes ou des pièces.
- Utiliser des pochettes et des boîtes antistatiques pour stocker, déplacer ou expédier des cartes de circuits imprimés.



### DES ORGANES MOBILES peuvent provoquer des blessures.

- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.



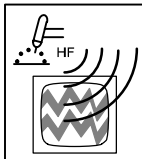
### LES FILS DE SOUDAGE peuvent provoquer des blessures.

- Ne pas appuyer sur la gâchette avant d'en avoir reçu l'instruction.
- Ne pas diriger le pistolet vers soi, d'autres personnes ou toute pièce mécanique en engageant le fil de soudage.



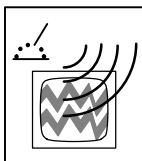
### DES ORGANES MOBILES peuvent provoquer des blessures.

- Rester à l'écart des organes mobiles comme le ventilateur.
- Maintenir fermés et fixement en place les portes, panneaux, recouvrements et dispositifs de protection.



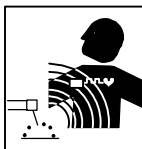
### LE RAYONNEMENT HAUTE FRÉQUENCE (H.F.) risque de provoquer des interférences.

- Le rayonnement haute fréquence peut provoquer des interférences avec les équipements de radio-navigation et de communication, les services de sécurité et les ordinateurs.
- Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un électricien qualifié les interférences résultant de l'installation.
- Si le FCC signale des interférences, arrêter immédiatement l'appareil.
- Effectuer régulièrement le contrôle et l'entretien de l'installation.
- Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence, maintenir les éclateurs à une distance correcte et utiliser une terre et un blindage pour réduire les interférences éventuelles.



### LE SOUDAGE À L'ARC risque de provoquer des interférences.

- L'énergie électromagnétique risque de provoquer des interférences pour l'équipement électronique sensible tel que les ordinateurs et l'équipement commandé par ordinateur tel que les robots.
- Veiller à ce que tout l'équipement de la zone de soudage soit compatible électromagnétiquement.
- Pour réduire la possibilité d'interférence, maintenir les câbles de soudage aussi courts que possible, les grouper, et les poser aussi bas que possible (ex. par terre).
- Veiller à souder à une distance de 100 mètres de tout équipement électronique sensible.
- Veiller à ce que ce poste de soudage soit posé et mis à la terre conformément à ce mode d'emploi.
- En cas d'interférences après avoir pris les mesures précédentes, il incombe à l'utilisateur de prendre des mesures supplémentaires telles que le déplacement du poste, l'utilisation de câbles blindés, l'utilisation de filtres de ligne ou la pose de protecteurs dans la zone de travail.



### LES CHAMPS MAGNÉTIQUES peuvent affecter les stimulateurs cardiaques.

- Porteurs de stimulateur cardiaque, restez à distance.
- Les porteurs d'un stimulateur cardiaque doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de gougeage ou de soudage par points.

## 1-4. Principales normes de sécurité

*Safety in Welding and Cutting*, norme ANSI Z49.1, de l'American Welding Society, 550 N.W. Lejeune Rd, Miami FL 33126

*Safety and Health Standards*, OSHA 29 CFR 1910, du Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

*Recommended Safe Practice for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances*, norme AWS F4.1, de l'American Welding Society, 550 N.W. Lejeune Rd, Miami FL 33126

*National Electrical Code*, NFPA Standard 70, de la National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

*Safe Handling of Compressed Gases in Cylinders*, CGA Pamphlet P-1, de la Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

*Règles de sécurité en soudage, coupage et procédés connexes*, norme CSA W117.2, de l'Association canadienne de normalisation, vente de normes, 178 Rexdale Boulevard, Rexdale (Ontario) Canada M9W 1R3.

*Safe Practices For Occupation And Educational Eye And Face Protection*, norme ANSI Z87.1, de l'American National Standards Institute, 1430 Broadway, New York, NY 10018.

*Cutting and Welding Processes*, norme NFPA 51B, de la National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

## 1-5. Information sur les champs électromagnétiques

Données sur le soudage électrique et sur les effets, pour l'organisme, des champs magnétiques basse fréquence

Le courant de soudage, pendant son passage dans les câbles de soudage, causera des champs électromagnétiques. Il y a eu et il y a encore un certain souci à propos de tels champs. Cependant, après avoir examiné plus de 500 études qui ont été faites pendant une période de recherche de 17 ans, un comité spécial ruban bleu du National Research Council a conclu: "L'accumulation de preuves, suivant le jugement du comité, n'a pas démontré que l'exposition aux champs magnétiques et champs électriques à haute fréquence représente un risque à la santé humaine". Toutefois, des études sont toujours en cours et les preuves continuent à être examinées. En attendant que les conclusions finales de la recherche soient établies, il vous serait souhaitable de réduire votre exposition aux champs électromagnétiques pendant le soudage ou le coupage.

Afin de réduire les champs électromagnétiques dans l'environnement de travail, respecter les consignes suivantes :

- 1 Garder les câbles ensemble en les torsadant ou en les attachant avec du ruban adhésif.
- 2 Mettre tous les câbles du côté opposé de l'opérateur.
- 3 Ne pas courber pas et ne pas entourer pas les câbles autour de votre corps.
- 4 Garder le poste de soudage et les câbles le plus loin possible de vous.
- 5 Relier la pince de masse le plus près possible de la zone de soudure.

### Consignes relatives aux stimulateurs cardiaques :

Les personnes qui portent un stimulateur cardiaque doivent avant tout consulter leur docteur. Si vous êtes déclaré apte par votre docteur, il est alors recommandé de respecter les consignes ci-dessus.


# SECTION 2 – DEFINITIONS

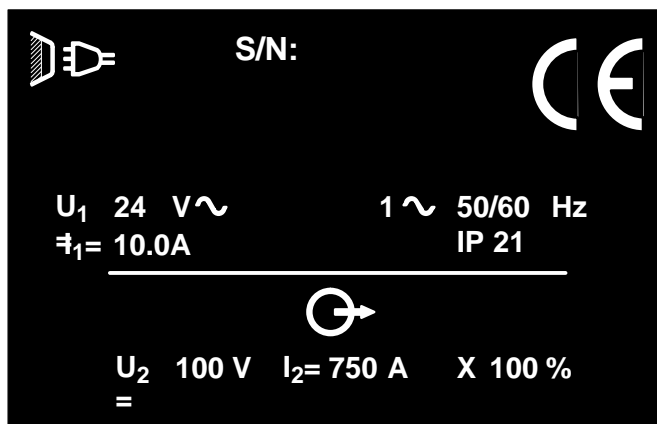
## 2-1. Warning Label Definitions



- A. Warning! Watch Out! There are possible hazards as shown by the symbols.
- B. Drive rolls can injure fingers.
- C. Welding wire and drive parts are at welding voltage during operation – keep hands and metal objects clear.
  - 1 Electric shock can kill.
  - 1.1 Wear dry insulating gloves. Do not touch electrode with bare hand. Do not wear wet or damaged gloves.
  - 1.2 Protect yourself from electric shock by insulating yourself from work and ground.
  - 1.3 Disconnect input plug or power before working on machine.
- 2 Breathing welding fumes can be hazardous to your health.
  - 2.1 Keep your head out of the fumes.
  - 2.2 Use forced ventilation or local exhaust to remove the fumes.
  - 2.3 Use ventilating fan to remove fumes.
- 3 Welding sparks can cause explosion or fire.
  - 3.1 Keep flammables away from welding. Don't weld near flammables.
  - 3.2 Welding sparks can cause fires. Have a fire extinguisher nearby and have a watch person ready to use it.
  - 3.3 Do not weld on drums or any closed containers.
- 4 Arc rays can burn eyes and injure skin.
  - 4.1 Wear hat and safety glasses. Use ear protection and button shirt collar. Use welding helmet with correct shade of filter. Wear complete body protection.
- 5 Become trained and read the instructions before working on the machine or welding.
- 6 Do not remove or paint over (cover) the label.


## 2-2. Rating Label For CE Products






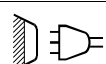










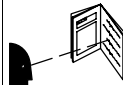

 For label location see Section 4-4.



ST-178 794-A

## 2-3. Symbols And Definitions

**Note**  Some symbols are found only on CE products.

<b>A</b>	Amperes	<b>V</b>	Volts		Alternating Current	<b>X</b>	Duty Cycle
<b>IP</b>	Degree Of Protection	<b>Hz</b>	Hertz	<b>U<sub>1</sub></b>	Primary Voltage		Wire Feed
	Jog		Output		Trigger		Line Connection
	Press To Set	<b>U<sub>2</sub></b>	Load Voltage		Trigger Hold On		Trigger Hold Off
	Purge		Spot Weld Time		Spot Weld		Continuous Weld
	Burnback Time		Preflow Time		Postflow Time		Read Instructions
	Increase	<b>I<sub>1</sub></b>	Primary Current	<b>I<sub>2</sub></b>	Rated Current		

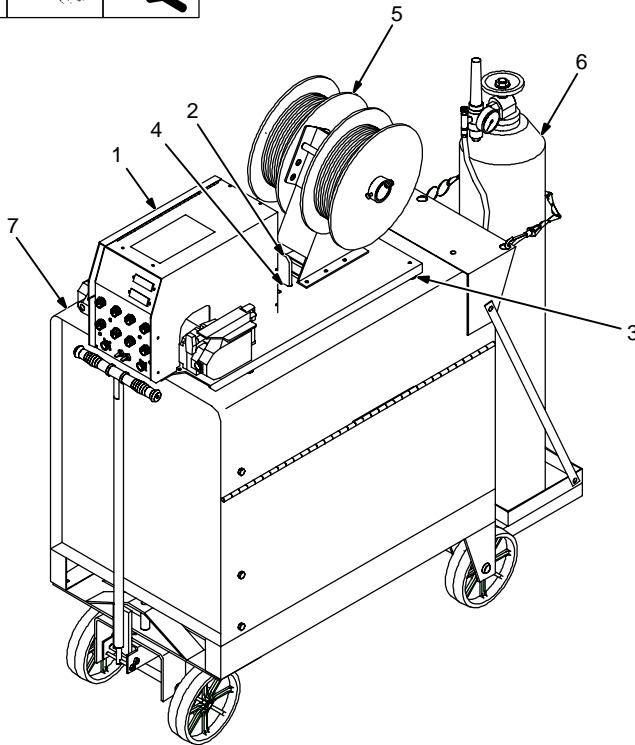
# SECTION 3 – INTRODUCTION

## 3-1. Specifications

Type of Input Power	Welding Power Source Type	Wire Feed Speed Range	Wire Diameter Range	Welding Circuit Rating	IP Rating	Overall Dimensions	Weight
24 Volts AC Single-Phase 10 Amperes 50/60 Hertz	Constant Voltage (CV) DC With 14-Pin And Contactor Control	Standard: 50 To 780 ipm (1.3 To 19.8 mpm)  Optional High Speed: 90 To 1400 ipm (2.3 To 35.6 mpm)	.023 To 1/8 in (0.6 To 3.2 mm)  Max Spool Weight: 60 lb (27 kg)	100 Volts, 750 Amperes, 100% Duty Cycle	IP 23	Length: 32 in (812 mm)  Width: 18 in (457 mm)  Height: 14 in (356 mm)	78 lb (35 kg)

# SECTION 4 – INSTALLATION

## 4-1. Site Selection

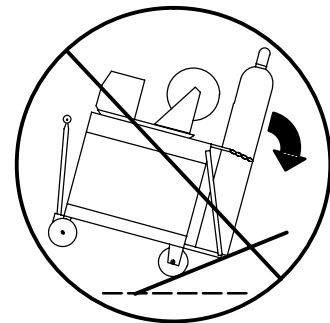
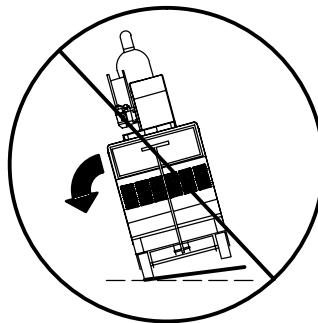
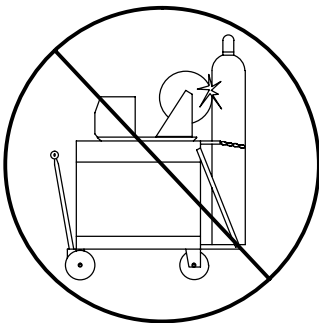


- 1 Wire Feeder
- 2 Lifting Eye
- 3 Rubber Feet
- 4 Slot

Choose slot that allows all rubber feet to sit securely on top of welding power source.

- 5 Wire Spool/Reel
- 6 Gas Cylinder (Customer Supplied)
- 7 Welding Power Source

- ▲ Do not put feeder where welding wire hits cylinder.
- ▲ Do not move or operate equipment when it could tip.

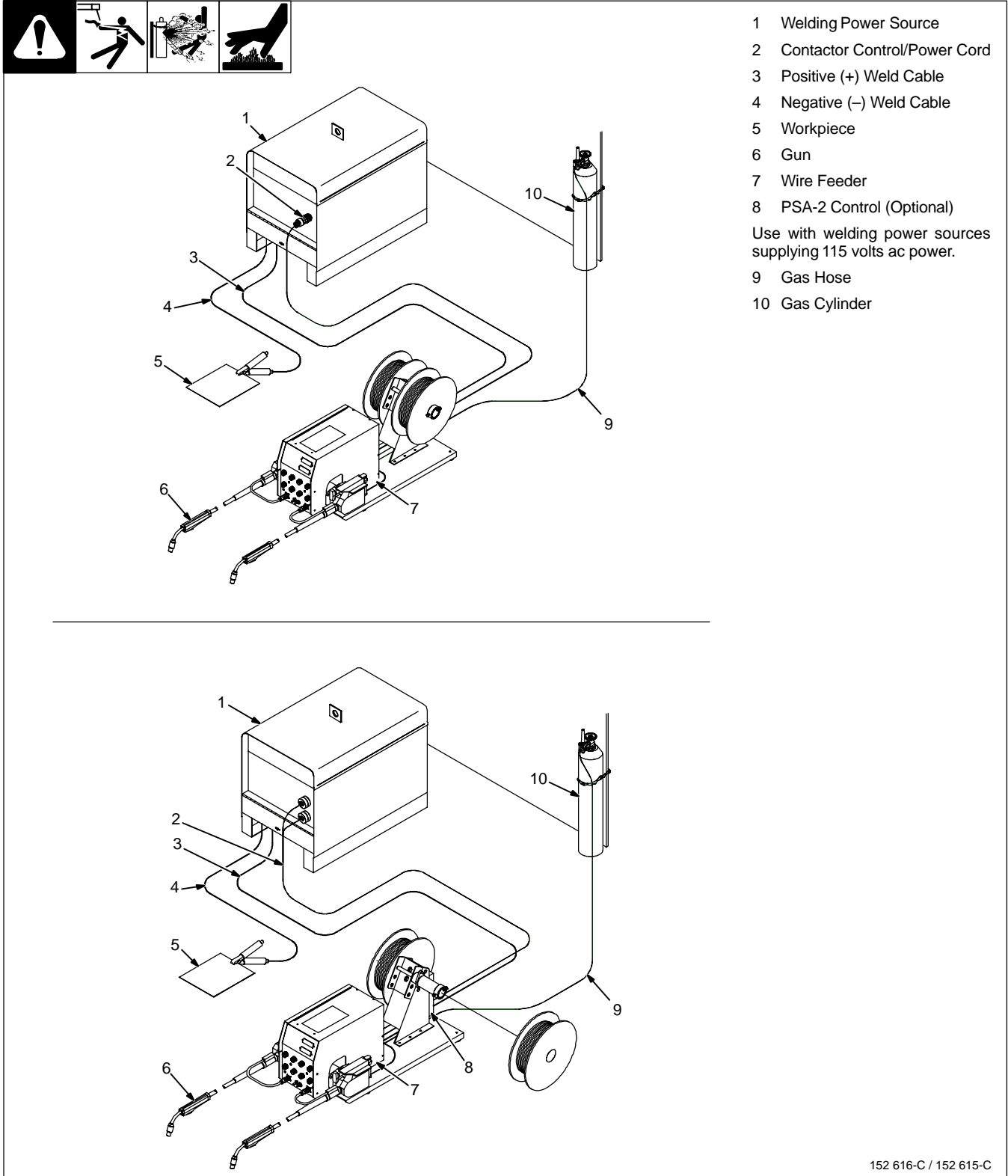


Ref. ST-152 468-A / ST-152 566-B

## 4-2. Gun Recommendation Table

Process	Gun
GMAW – Hard or Cored Wires	Roughneck C-Series Guns: 300, 400, 500, And 600 Amp.
FCAW – Self-Shielding Wires	FC-1260 Or FC-1150

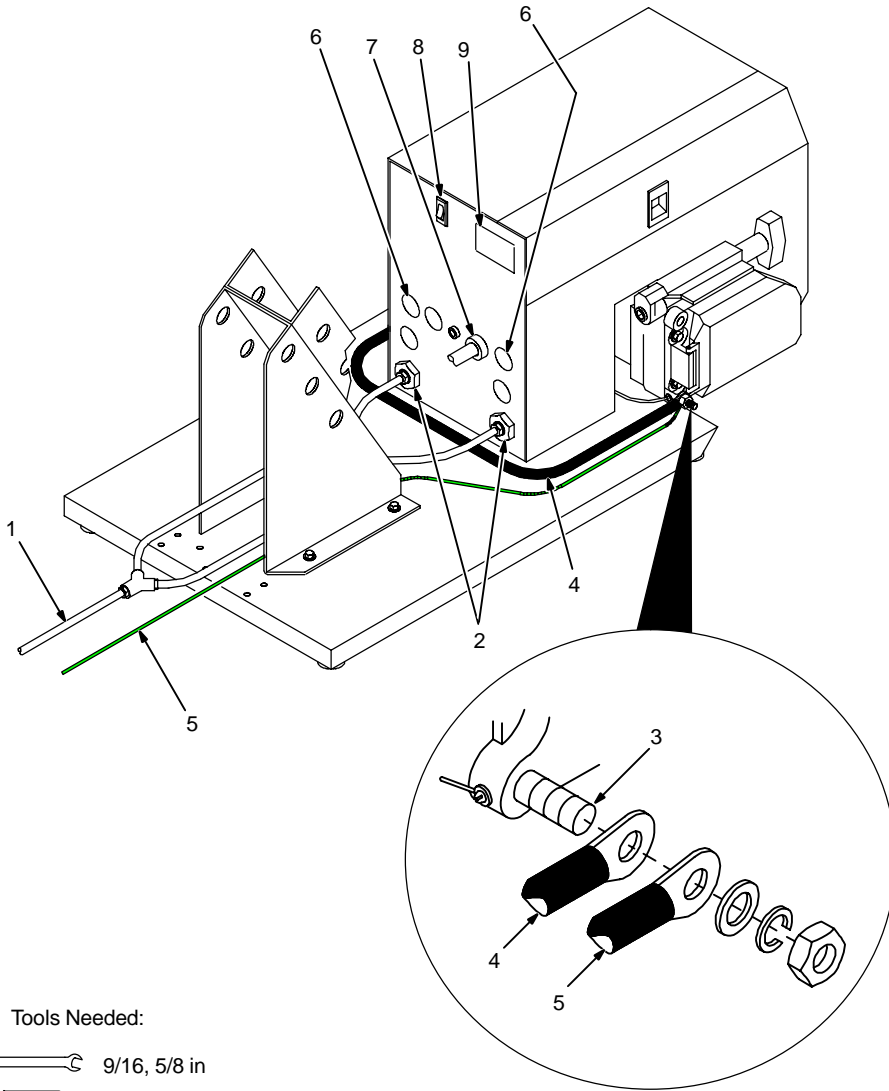
## 4-3. Equipment Connection Diagrams



152 616-C / 152 615-C

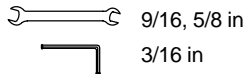


## 4-4. Rear Panel Connections




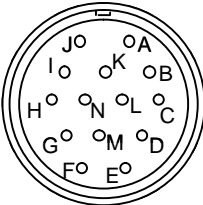
- 1 "Y" Adapter Gas Hose (Supplied)
- 2 Shielding Gas Valve Fitting  
Requires fitting with 5/8-18 right-hand threads.
- 3 Weld Cable Terminal
- 4 Jumper Weld Cable
- 5 Weld Cable
- 6 Optional Current Sensor Connections
- 7 14-Pin Cord
- 8 Power Switch
- 9 Rating Label Location

Tools Needed:



Ref. 800 353-B

## 4-5. 14-Pin Plug Information

 REMOTE 14	Pin*	Pin Information
	A	24 volts ac with respect to socket G.
	B	Contact closure to A completes 24 volts ac contactor control circuit.
	G	Circuit common for 24 volts AC circuit.
	C	+10 volts dc output to remote control with respect to socket D.
	D	Remote control circuit common.
	E	0 to +10 volts dc input command signal from remote control with respect to socket D.
	H	Voltage feedback; 0 to +10 volts dc, 1 volt per 10 arc volts.
	F	Current feedback; 0 to +10 volts dc, 1 volt per 100 amperes.

\*The remaining pins are not used.

## 4-6. Wire Type, Size, And Feed Speed Capability Table

Motor Speed	Wire Type	Wire Size	Feed Speed Capability
Standard	All	.023 To 5/64 in (0.6 To 2 mm)	50 To 780 ipm (1.3 To 19.8 mpm)
Standard	All	3/32 To 7/64 in (2.4 To 2.8 mm)	50 To 700 ipm (1.3 To 17.8 mpm)
Standard	All	1/8 in (3.2 mm)	50 To 300 ipm (1.3 To 7.6 mpm)
Optional High Speed	All	.023 To 5/64 in (0.6 To 2 mm)	92 To 1440 ipm (2.3 To 35.6 mpm)

## 4-7. Motor Start Control

To change wire feed starting speed, proceed as follows:

Turn Off wire feeder and welding power source.

Remove wrapper.

- 1 Front Panel

Front panel shown open for illustration purposes.

- 2 Left Side Inner Control Panel

It may be necessary to remove panel to access Motor Start Control. Remove panel only as far as required if options are attached to panel.

- 3 Motor Board PC1
- 4 Motor Start Control Potentiometer R70

Turn potentiometer clockwise to increase time it takes the motor to ramp up to speed. Remove protective white rubber cap before making adjustment. Adjust potentiometer R70 using a small nonconductive screwdriver.

Reinstall left side inner control panel if it was removed.

Reinstall wrapper.

**Tools Needed:**

Non-Conductive

1/4 in

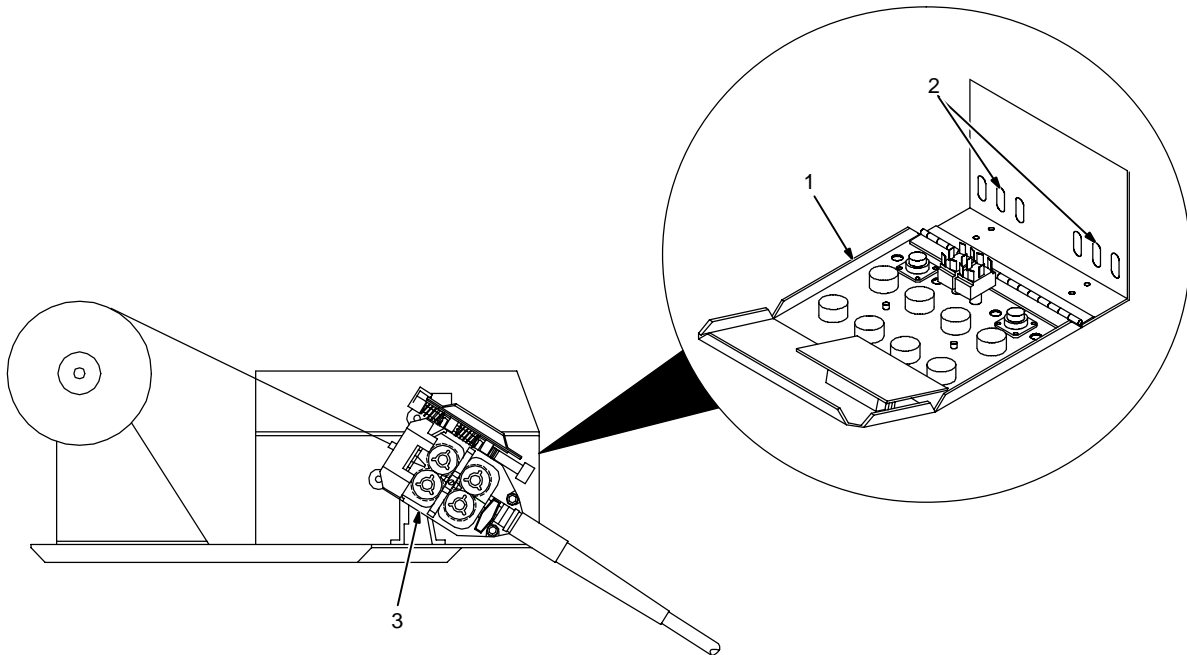
Ref. 143 259-G / Ref. SB-183 121-C

## 4-8. Rotating The Drive Assembly

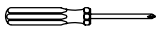


Remove screws (6) from front edge of wrapper, and loosen screws on back edge of wrapper.

- 1 Front Panel
- 2 Drive Assembly Rotation Adjustment Opening
- 3 Drive Assembly



Tools Needed:

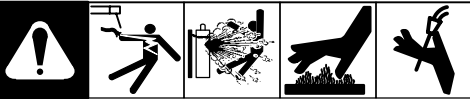


1/4 in

3/16 in

Ref. 143 259-G / Ref. ST-153 093-A

## 4-9. Installing And Threading Welding Wire



Be sure that outlet cable has proper size liner for the welding wire size. When installing gun, position liner extending from outlet wire guide as close as possible to drive rolls without touching.

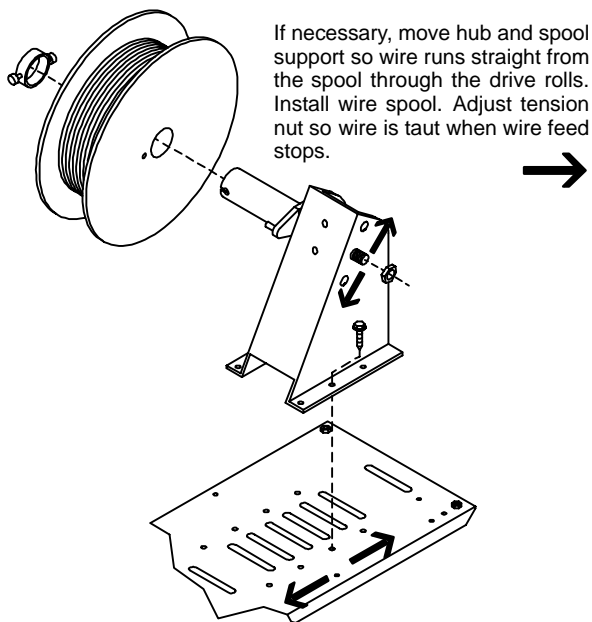
Install gun. Lay gun cable out straight. Cut off end of wire. Push wire through guides up to drive rolls; continue to hold wire. Press Jog button to feed wire out gun.

For soft wire or small diameter stainless steel wire, use 2 drive rolls and set drive roll pressure from 0 to a maximum of 4 on the pressure indicator scale (so that only the inner spring is compressed). This setting will generally give the best performance for these types of wires.

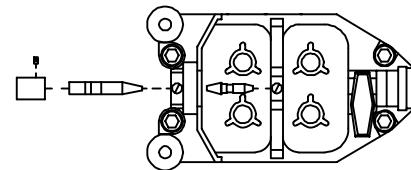
To adjust drive roll pressure, hold nozzle

about 2 in (51 mm) from nonconductive surface and press gun trigger to feed wire against surface. Tighten knob so wire does not slip. Do not overtighten. If contact tip is completely blocked, wire should slip at the feeder (see pressure adjustment above).

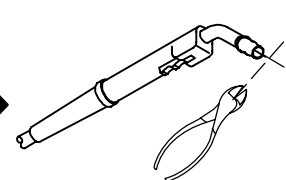
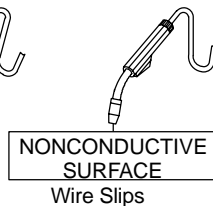
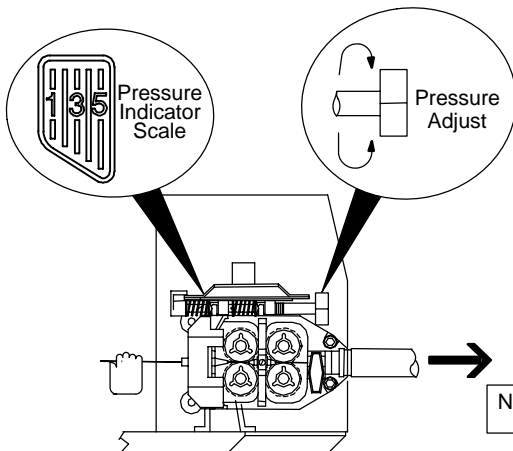
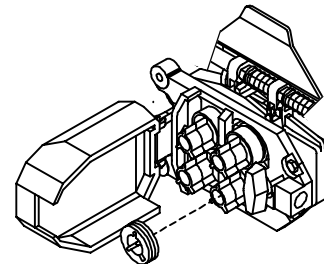
Cut wire off. Close cover.



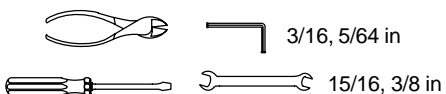
Install wire guides and anti-wear guide.



Install drive rolls.



Tools Needed:

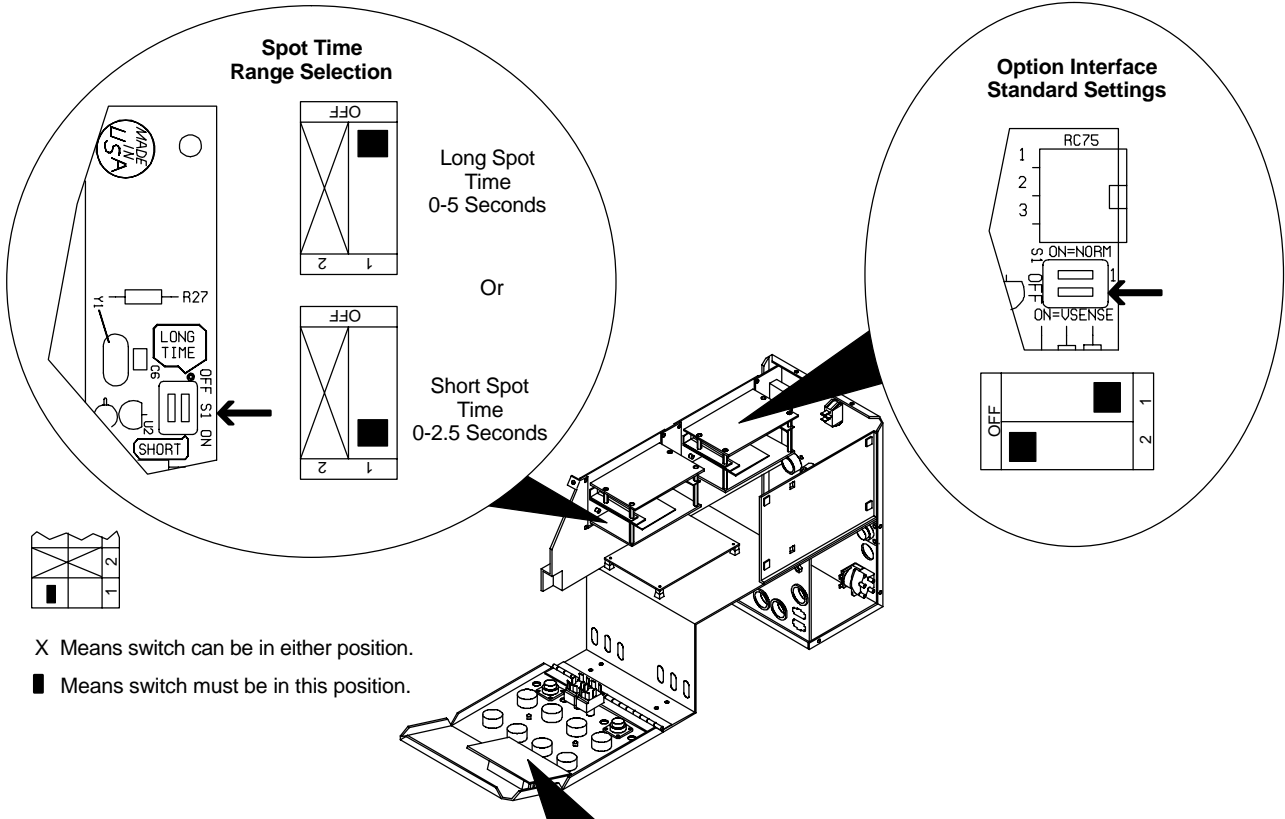


Ref. ST-156 929-A / Ref. SC-150 922 / Ref. ST-156 930 / S-0627-A

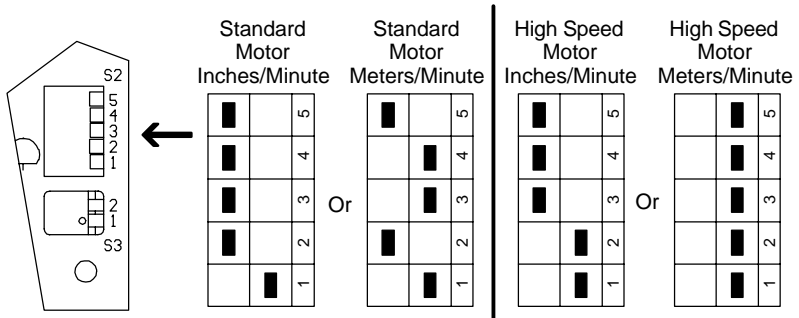
# 4-10. Optional Equipment DIP Switch Settings



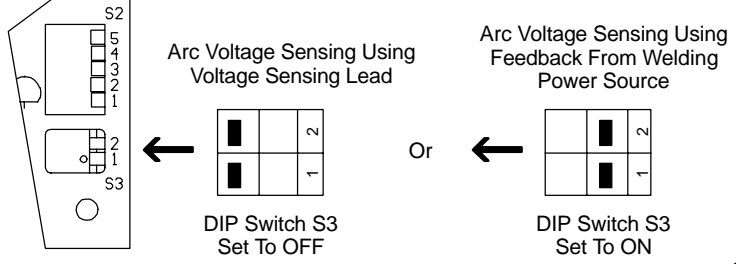
If wire feeder is equipped with a voltage sensing lead, set DIP switch S3 to the OFF position (up). If wire feeder is NOT equipped with a voltage sensing lead, set DIP switch S3 to the ON position (down).



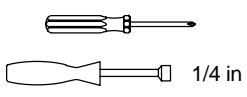
### Digital Meter Functions



### Voltage Sensing Function

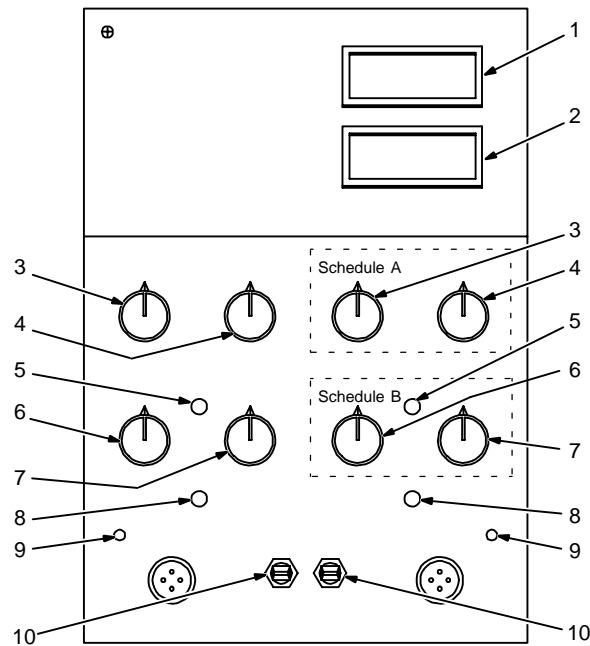


Tools Needed:



# SECTION 5 – OPERATION

## 5-1. Front Panel Controls



ST-152 647

1 Voltmeter (Optional) (See Section 4-10)


2 Wire Speed Meter (Optional)

Factory set to display inches per minute. If display of meters per minute is desired, see Section 4-10.

3 Schedule A Wire Speed Control

The scale is calibrated in inches per minute x 100 and meter per minute.

4 Schedule A Voltage Control (Optional)

 For dual schedule applications, a dual schedule switch is required for the gun. Obtain a proper dual schedule switch and install according to its instructions.

5 Schedule B Indicator Light (Optional)

6 Schedule B Wire Speed Control (Optional)

7 Schedule B Voltage Control (Optional)

8 Press To Set Button (Optional)

Press and hold button to preset Schedule B wire feed speed and/or voltage.

9 Left And Right Indicator Lights

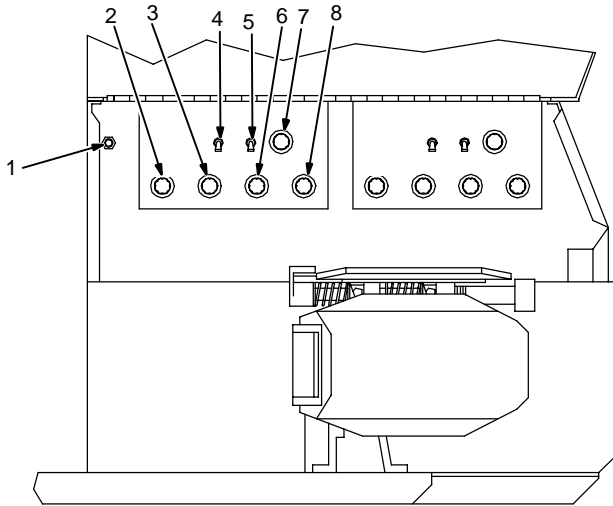
10 Jog/Purge Switch

Push up to momentarily feed welding wire at speed set on Wire Speed control without energizing welding circuit or shielding gas valve.

Push down to momentarily energize gas valve to purge air from gun or adjust gas regulator.

Center position is off.

## 5-2. Overload Protection And Optional Side Panel Controls



802 433-A

**1 Circuit Breaker CB1**

CB1 protects wire feed motor from overload. Press to reset.

**2 Preweld Control**

Control sets time gas flows before welding wire is energized.

**3 Spot Time Control**

Factory set for 0 to 5 seconds of spot time. If 0 to 2.5 seconds is desired, see Section 4-10.

**4 Spot Continuous Switch**

Switch selects an untimed continuous weld or a timed spot weld.

**5 Trigger Hold Switch (Optional)**

Push up to weld without holding gun trigger throughout the weld cycle.

To start weld, press and release gun trigger within three seconds after an arc has been struck. To end weld, press and release gun trigger.

**6 Burnback Control**

Control adjusts time welding wire is energized after wire feed stops.

**7 Run-In Control**

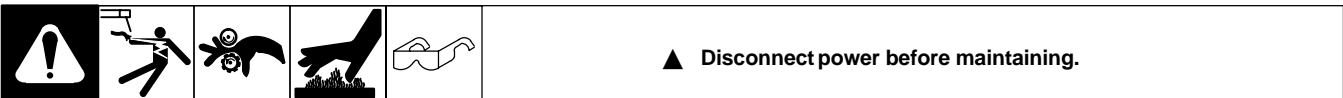
Control sets run-in wire speed before arc initiation.

**8 Postflow Control**

Control sets time gas flows after completion of burnback. Close side door.

# SECTION 6 – MAINTENANCE AND TROUBLESHOOTING

## 6-1. Routine Maintenance



<b>3 Months</b>							
Replace unreadable labels.			Clean and tighten weld terminals.		Repair or replace cracked weld cable.		
Replace cracked parts.		Check 14-pin cord.		Check gas hose and fittings.		Check gun cable.	
<b>6 Months</b>							
Blow out or vacuum inside. During heavy service, clean monthly.		OR		Clean drive rolls.			

## 6-2. Troubleshooting



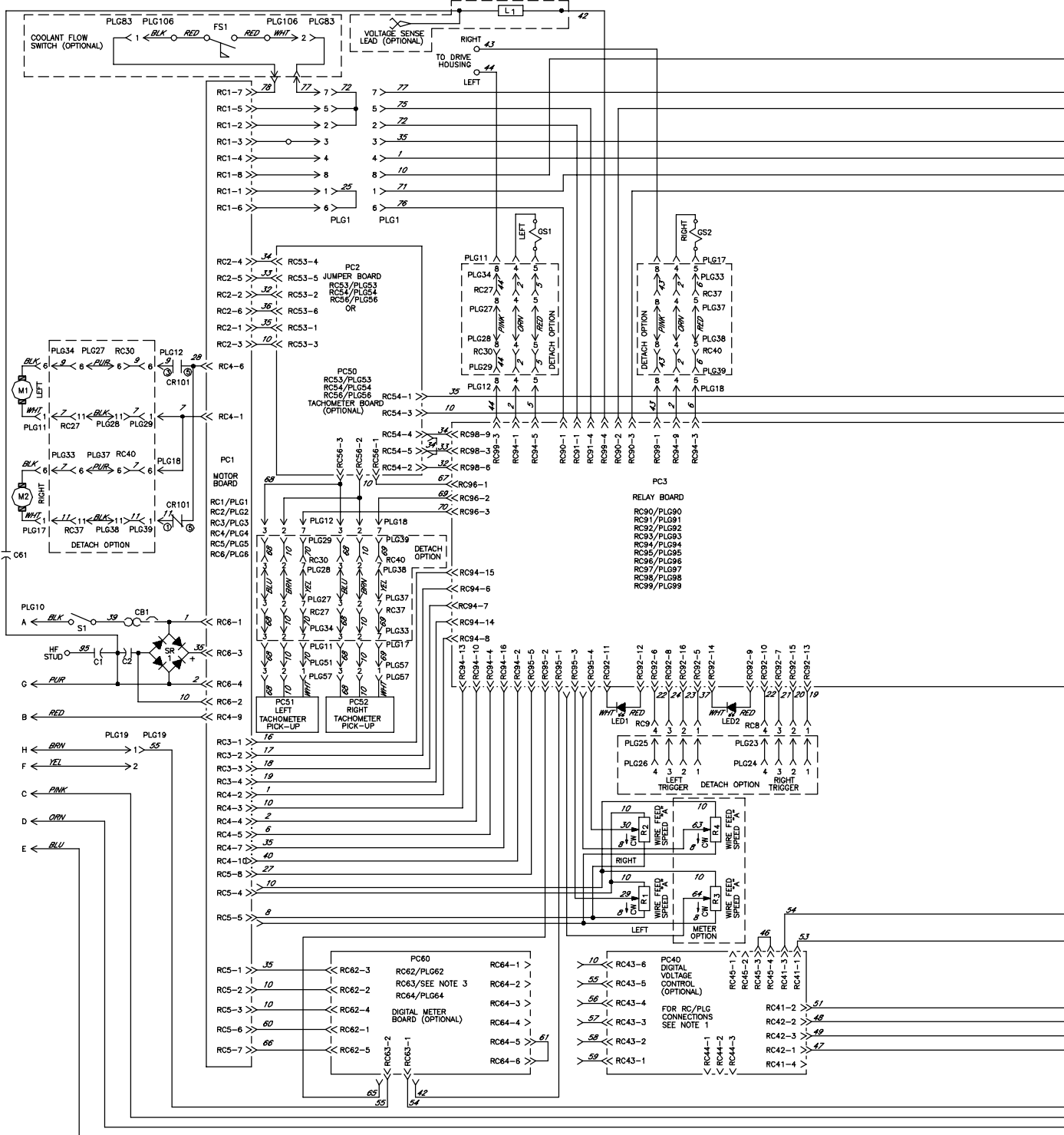
▲ Disconnect power before troubleshooting

Trouble	Remedy
Wire feeds, shielding gas flows, but electrode wire is not energized.	Check interconnecting cord connections. If secure, check cord for continuity and repair or replace (see Sections 4-3 and 4-4).
Wire feeder is on, meter(s) do not light up, motor does not run, gas valve and welding power source contactor do not pull in.	Check and reset CB1 (see Section 5-2).
Electrode wire feeding stops or feeds erratically during welding.	Check gun trigger connection. See gun Owner's Manual.
	Check gun trigger. See gun Owner's Manual.
	Readjust hub tension and drive roll pressure (see Section 4-9).
	Change to correct size drive roll (see Table 8-1).
	Clean or replace dirty or worn drive roll.
	Incorrect size or worn wire guides.
	Replace contact tip or liner. See gun Owner's Manual.
	Remove weld spatter or foreign matter from around nozzle opening.
Motor runs slowly.	Check for correct input voltage.
Wire does not feed until trigger is pulled, but continues to feed after trigger is released, and trigger hold is not on.	Check for a short between welding gun trigger leads and weld cable. Repair short or replace welding gun.
Gas valve in feeder is rattling loudly along with possible erratic or slow wire feed speed.	Check for a short between welding gun trigger leads and weld cable. Repair short or replace welding gun.
Unit does not switch out of Run-In Speed.	When using this unit with certain older style Miller CV power sources, a weld current sensor (Part No. 160 963) must be used. Power sources include the Deltaweld prior to Serial No. KG141349 and the Dimension prior to Serial No. KC253517.
Wire feeder power is on, displays light up, but unit is inoperative.	Check welding gun trigger leads for continuity, and repair leads or replace gun.
Schedule A Wire Feed Speed works, but Schedule B Wire Feed Speed does not work or is erratic.	DIP Switch S1(1) on Option Interface Board PC70 must be in the On position (see Section 4-10).
Wire Feed Speed Meter display does not match actual wire feed speed.	Set DIP Switch S2 on Meter Board PC60 in Inches/Minute mode (see Section 4-10).
Actual arc voltage display on meter is held after trigger is released, or arc voltage does not change while welding.	Set DIP Switch S2 on Meter Board PC60 in Voltage Monitor mode (see Section 4-10).



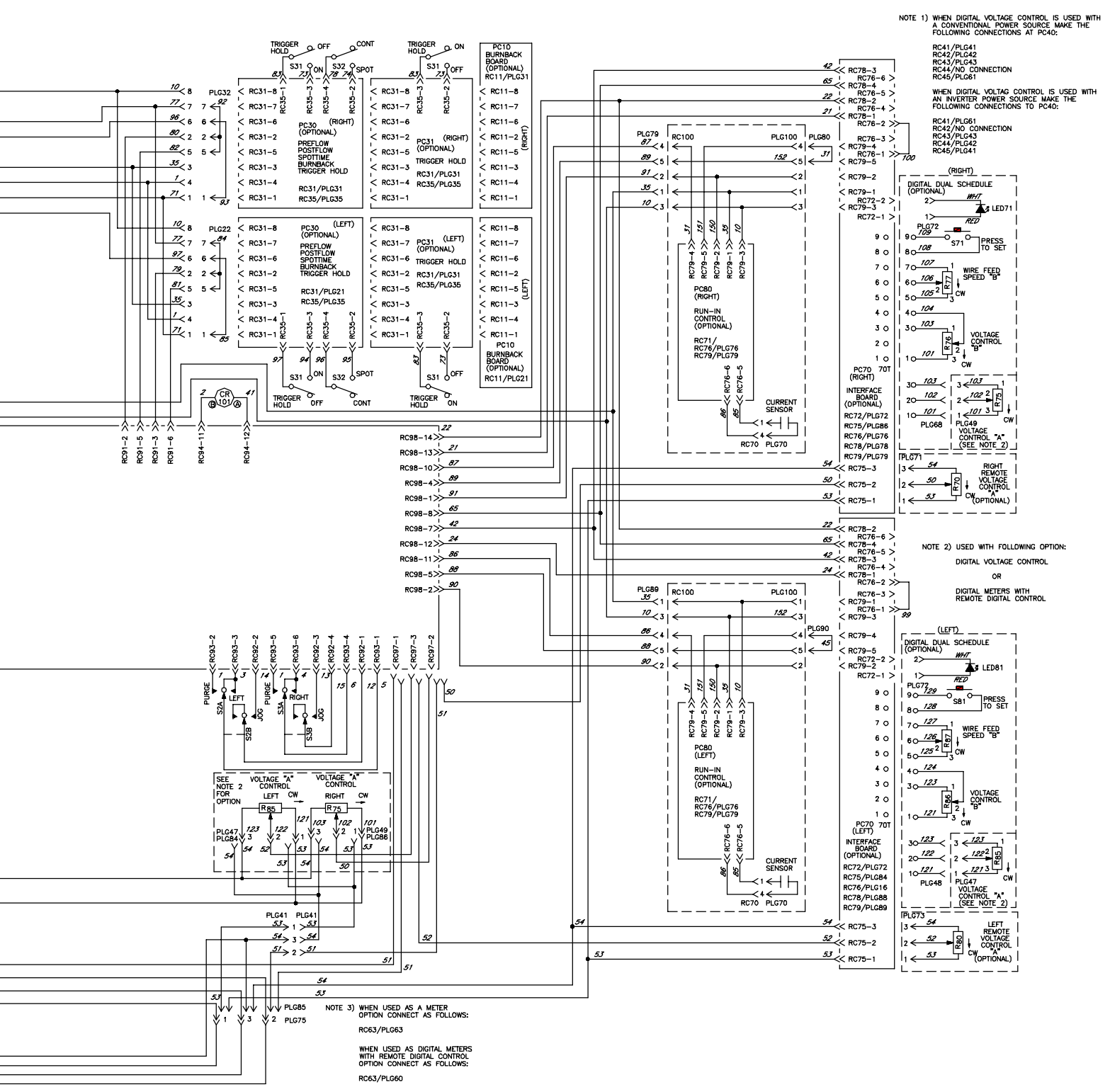


# SECTION 7 – ELECTRICAL DIAGRAM



**WARNING**  
 Do not touch live electrical parts.  
 Disconnect input power or stop engine before servicing.  
 Do not operate with covers removed.  
 Use only factory specified parts and use, or service this unit.  
**ELECTRIC SHOCK HAZARD**

Figure 7-1. Circuit Diagram



NOTE 1) WHEN DIGITAL VOLTAGE CONTROL IS USED WITH A CONVENTIONAL POWER SOURCE MAKE THE FOLLOWING CONNECTIONS AT PC40:

- RC41/PLG41
- RC42/PLG42
- RC43/PLG43
- RC44/PLG44
- RC45/PLG45

WHEN DIGITAL VOLTAGE CONTROL IS USED WITH AN INVERTER POWER SOURCE MAKE THE FOLLOWING CONNECTIONS TO PC40:

- RC41/PLG61
- RC42/NO CONNECTION
- RC43/PLG43
- RC44/PLG42
- RC45/PLG41

NOTE 2) USED WITH FOLLOWING OPTION:

- DIGITAL VOLTAGE CONTROL
- OR
- DIGITAL METERS WITH REMOTE DIGITAL CONTROL


NOTE 3) WHEN USED AS A METER OPTION CONNECT AS FOLLOWS:

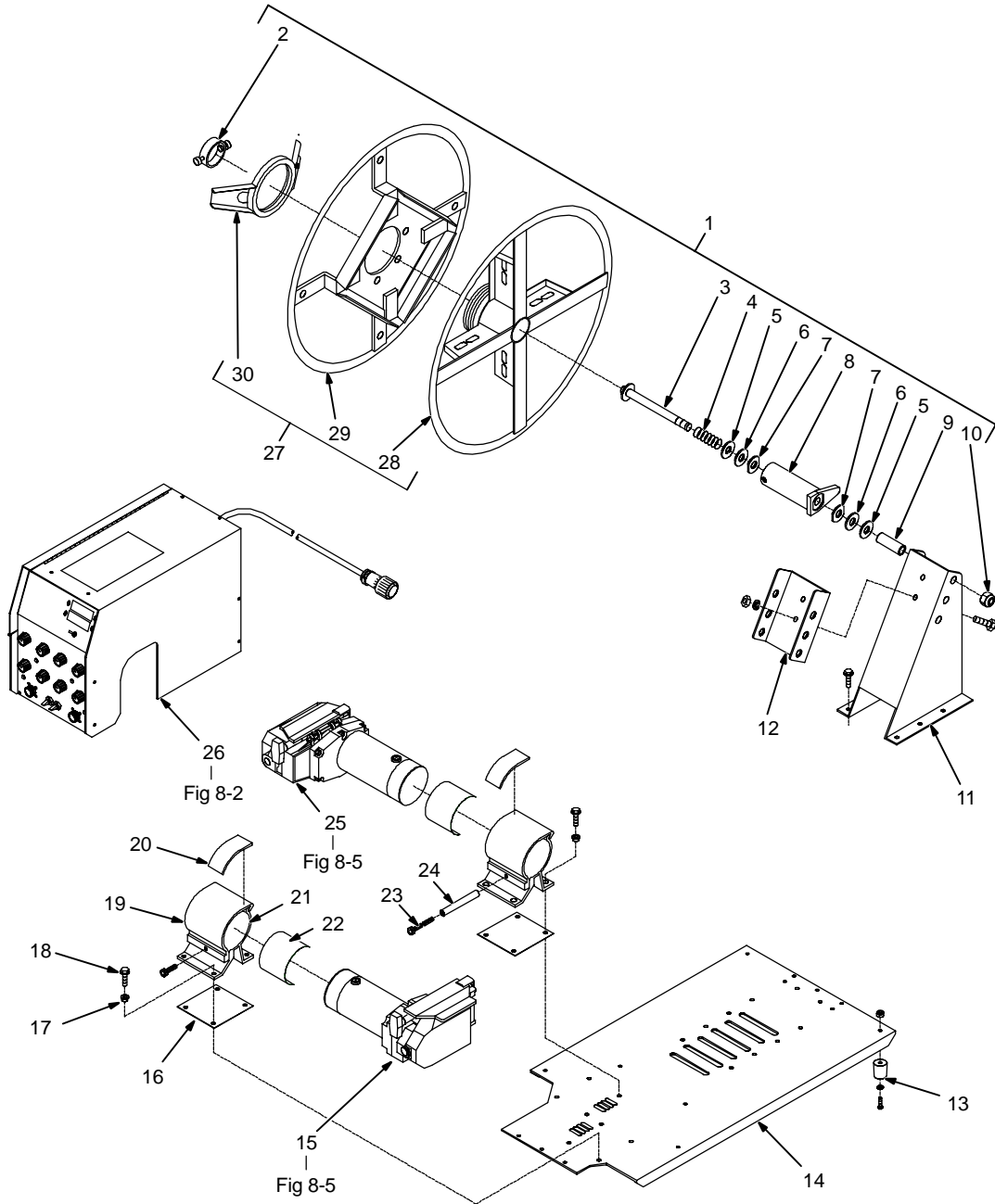
RC63/PLG63

WHEN USED AS DIGITAL METERS WITH REMOTE DIGITAL CONTROL OPTION CONNECT AS FOLLOWS:

RC63/PLG60

# SECTION 8 – PARTS LIST

 Hardware is common and not available unless listed.



143 225-K


**Figure 8-1. Main Assembly**

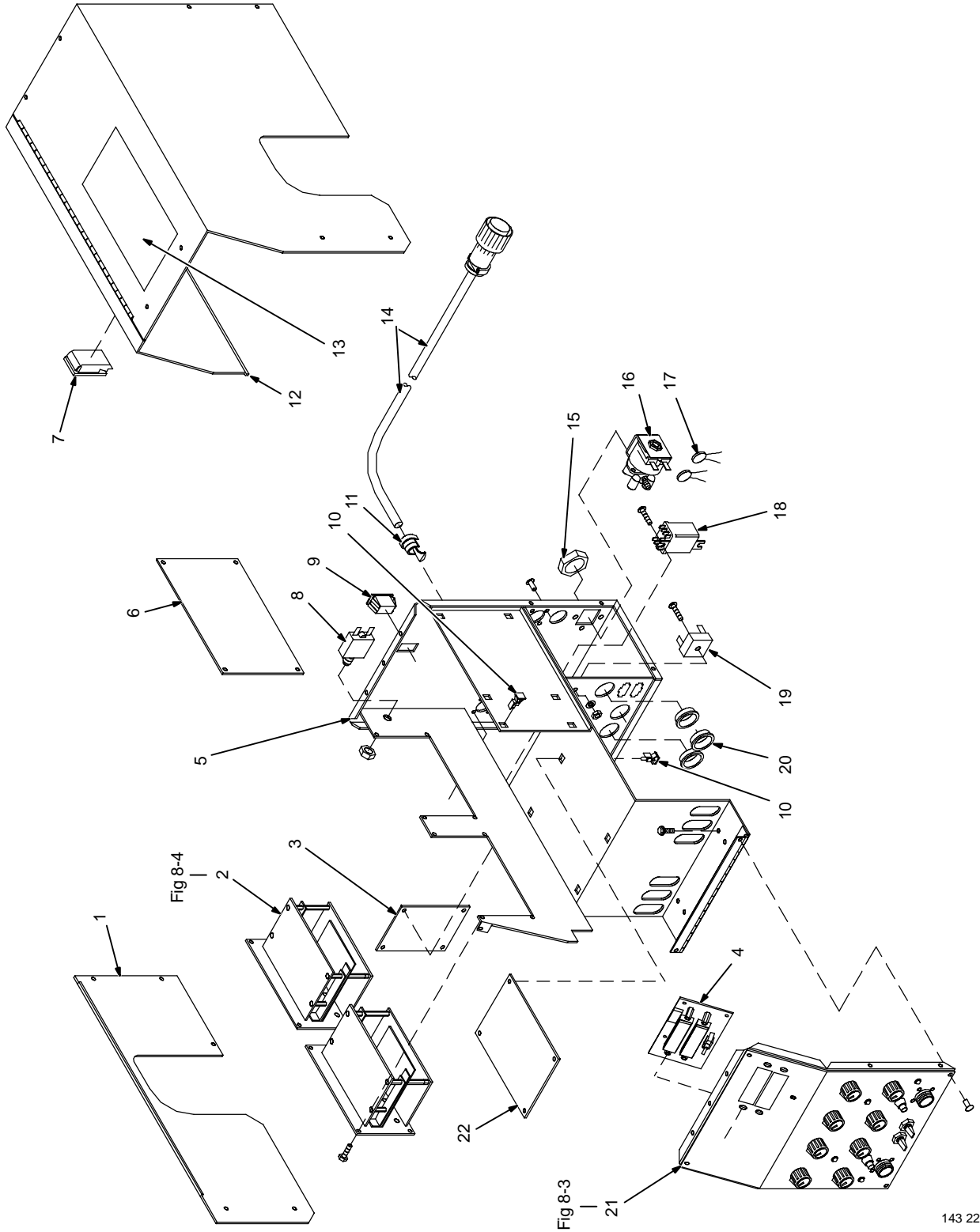
Item No.	Part No.	Description	Quantity
<b>Figure 8-1. Main Assembly</b>			
1	143 160	HUB & SPINDLE ASSEMBLY, (consisting of)	2
2	058 427	RING, retaining spool	1
3	180 573	SHAFT, support spool	1
4	010 233	SPRING, cprsn .970 OD x .120 wire x 1.250pld	1
5	057 971	WASHER, flat stl keyed 1.500dia x .125thk	2
6	010 191	WASHER, fbr .656 ID x 1.500 OD x .125thk	2
7	058 628	WASHER, brake stl	2
8	058 428	HUB, spool	1
9	071 730	TUBING, stl .875 OD x 12ga wall x 2.375	1
10	135 205	NUT, stl slflkg hex reg .625-11 w/nylon insert	1
11	141 411	SUPPORT, spool	1
12	142 838	BRACKET, mtg spool RH	1
13	134 306	FOOT, rubber 1.250dia x 1.375 high	4
14	139 226	BASE	1
15	Fig 8-5	WIRE DRIVE ASSEMBLY, RH	1
16	159 647	INSULATOR, motor clamp	2
17	159 360	INSULATOR, screw machine	8
18	602 009	SCREW, cap stl sch .250-20 x 1.250	2
19	156 243	CLAMP, motor top	2
20	083 639	WEATHERSTRIPPING, adh .125 x 1.500 (order by ft)	1ft
21	159 646	CLAMP, motor base	2
22	145 639	STRIP, buna N compressed sheet .062 x 4.000 x 4.000	2
23	143 152	SCREW, cap stl sch .250-20 x 5.000 (LH only)	2
24	139 752	SPACER, stl .500 OD x 12ga wall x 3.750 (LH only)	2
25	Fig 8-5	WIRE DRIVE ASSEMBLY, LH	1
26	Fig 8-2	CONTROL BOX	1
27	◆108 008	REEL, wire 60 lb (consisting of)	1
28	124 900	SUPPORT, reel spool	1
29	+168 104	RETAINER, spool support (consisting of)	1
	166 594	LABEL, caution falling wire reel can cause damage	1
30	168 103	NUT, spanner retaining	1
	143 838	CABLE, weld 26 in	1
	164 059	HOSE, gas	1

◆OPTIONAL

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

 Hardware is common and not available unless listed.



**Figure 8-2. Control Box**

143 226-G

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 8-2. Control Box (Fig 8-1 Item 26)</b>				
1		139 235	PANEL, side lower LH	1
2		Fig 8-4	CONTROL PANEL	2
3	PC2	134 994	CIRCUIT CARD, tach jumper	1
		◆180 314	DIGITAL DISPLAY, (consisting of)	1
		132 611	OPTICAL ENCODER DISC	1
3	PC50	132 370	CIRCUIT CARD, tachometer	1
		097 132	STAND-OFF, 6-32 x .375 lg	4
	R3,4	603 856	POTENTIOMETER, WW sltd sft 10/T 2W 10K ohm (Wire Feed Speed A)	2
	PLG5	130 203	CONNECTOR & SOCKETS	1
	PLG62	131 055	CONNECTOR & SOCKETS	1
	PLG64	167 361	CONNECTOR & SOCKETS	1
	PLG95	115 092	CONNECTOR & SOCKETS	1
		138 045	CONNECTOR & SOCKETS	1
	R75,85	603 856	POTENTIOMETER, WW sltd sft 10/T 2W 10K ohm (Voltage Control A)	2
	PLG84,86,97	131 204	CONNECTOR & SOCKETS	3
	PLG41,47,49,85	131 203	CONNECTOR & SOCKETS	4
	PLG41	115 090	CONNECTOR & SOCKETS	1
	PLG19	151 490	CONNECTOR, rect 21P	1
	PLG60,63	138 045	CONNECTOR & SOCKETS	2
		097 922	KNOB	2
			see Figure 8-3 & Figure 8-5 for additional parts	
4	PC60	157 719	CIRCUIT CARD, meter dual	1
	PC51	198 004	CIRCUIT CARD, digital tach	1
5		139 231	CASE SECTION, bottom/rear	1
6	PC1	198 037	CIRCUIT CARD, motor control	1
	PLG1	115 092	CONNECTOR & SOCKETS	1
	PLG2	115 093	CONNECTOR & SOCKETS	1
	PLG3	115 094	CONNECTOR & SOCKETS	1
	PLG4	115 091	CONNECTOR & SOCKETS	1
	PLG5	130 203	CONNECTOR & SOCKETS	1
	PLG6	136 810	CONNECTOR & SOCKETS	1
7		151 187	LATCH, slide flush	1
8	CB1	083 432	CIRCUIT BREAKER, man reset 1P 10A 250V	1
9	S1	111 997	SWITCH, rocker SPST 10A 250VAC (Power Switch)	1
10		134 201	STAND-OFF SUPPORT, PC card .312/.375	12
11		010 325	BUSHING, strain relief .840 ID x .875mtg hole	1
12		+139 229	WRAPPER	1
13		178 936	LABEL, warning general precautionary	1
13		134 464	LABEL, warning CE	1
14		164 368	CABLE, pwr	1
15		605 227	NUT, nylon hex jam .750NPST	2
16	GS1,2	125 785	VALVE, 24VAC 2 way custom port 1/8 orf	2
17	C1,2	147 856	CAPACITOR	1
18	CR101	072 817	RELAY, encl 24VAC DPDT	1
19	SR1	035 704	RECTIFIER, integ 40A 800V	1
20		030 170	BUSHING, snap-in nyl .750 ID x 1.000mtg hole	3
21		Fig 8-3	PANEL, front w/components	1
22	PC3	183 151	CIRCUIT CARD, relay control	1
	PLG92,94	131 052	CONNECTOR & SOCKETS	2
	PLG93	115 093	CONNECTOR & SOCKETS	1
	PLG95	135 409	CONNECTOR & PINS	1
	PLG96	131 204	CONNECTOR & SOCKETS	1
	PLG98	115 094	CONNECTOR & SOCKETS	1
	PLG11,17	115 092	CONNECTOR & SOCKETS	2
	PLG12,18	135 409	CONNECTOR & PINS	2
		120 304	BLANK, snap-in nyl .250mtg hole	4

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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**Figure 8-2. Control Box (Fig 8-1 Item 26) (Continued)**

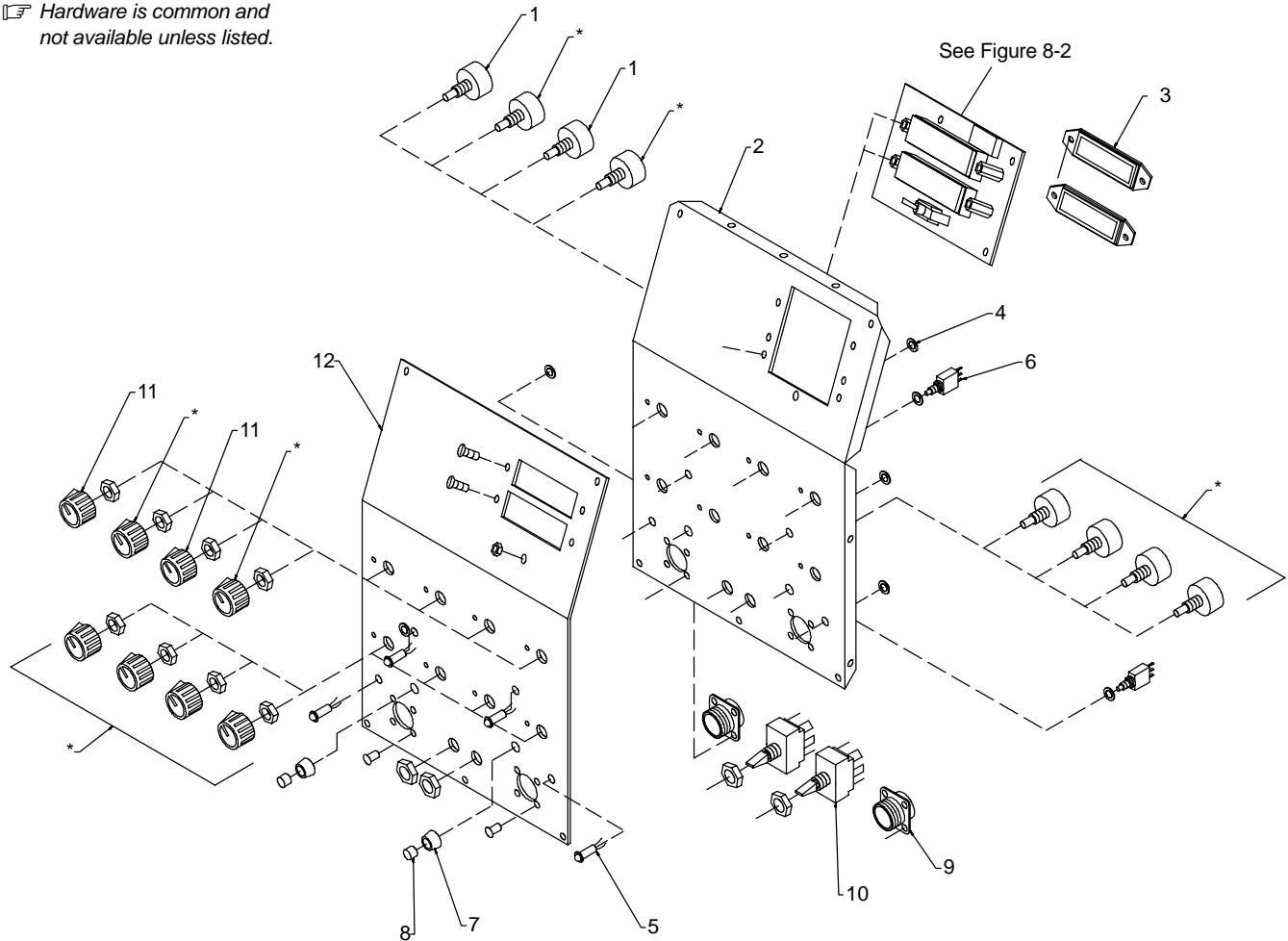
.....	119 951	...	BLANK, snap-in nyl .437mtg hole	6
.....	107 983	...	BLANK, snap-in nyl .500mtg hole	2
.....	024 103	...	BLANK, snap-in nyl .750mtg hole	1
.....	000 527	...	BLANK, snap-in nyl .875mtg hole	4

◆ **OPTIONAL**

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

☞ *Hardware is common and not available unless listed.*



\*See Option that is applicable

143 227-D

**Figure 8-3. Panel, Front w/Components**



Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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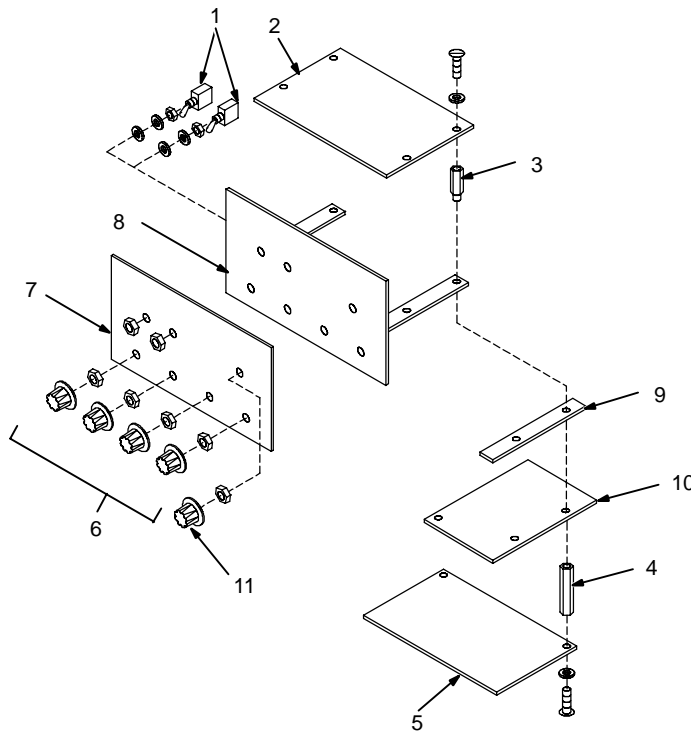
**Figure 8-3. Panel, Front w/Components (Fig 8-2 Item 21)**

.. 1	R1,2	073 562	POTENTIOMETER, C sltd sft 1/T 2W 10K ohm (Wire Feed Speed A)	2
.. 2		149 654	PANEL, front	1
.. 3		136 339	COVER, opening meter (not used with digital display option)	2
.. 4		134 209	NUT, speed push-on-type .250	2
.. 5	LED1,2	179 203	LED, 5100 2.0V 20mA green	2
		◆172 825	DIGITAL DUAL SCHEDULE, RH (consisting of)	1
		◆173 748	DIGITAL DUAL SCHEDULE, LH (consisting of)	1
.. 4		134 209	NUT, speed push-on-type .250	1
.. 5	LED71/81	179 203	LED, 5100 2.0V 20mA green	1
	PLG68/48	131 204	CONNECTOR & SOCKETS	1
	PLG72	131 054	CONNECTOR & SOCKETS	1
	R76,77/86,87	603 856	POTENTIOMETER, WW sltd sft 10/T 2W 10K ohm (Wire Feed Speed B/Voltage Control B)	2
.. 6	S71/81	150 982	SWITCH, PB MC SPDT 6A 125VAC (Press to Set)	1
.. 7		153 195	NUT, face	1
.. 8		150 981	BUTTON, switch black	1
		097 922	KNOB, pointer see Figure 8-4 For Additional Parts	2
.. 9	RC8,9	048 282	CONNECTOR w/SOCKETS	1
.. 10	S2,3	134 846	SWITCH, tgl SPTT 15A 125VAC (Jog/Purge)	2
.. 11		097 922	KNOB, pointer	2
.. 12			NAMEPLATE, (order by model and serial number)	1

◆OPTIONAL

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

Hardware is common and not available unless listed.



146 340-B

Figure 8-4. Control Panel

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 8-4. Control Panel (Fig 8-2 Item 2)

.. 1	.. S31,32	.. ♦011 770	.. SWITCH, tgl SPDT 6A 125VAC (Trigger Hold/Spot)	.. 2
.. 2	.. PC70	.. ♦♦150 591	.. CIRCUIT CARD, option interface	.. 1
..	.. PLG16,54,76	.. ♦♦115 093	.. CONNECTOR & SOCKETS	.. 3
..	.. PLG78,88	.. ♦♦115 094	.. CONNECTOR & SOCKETS	.. 2
..	.. PLG79,89	.. ♦♦115 091	.. CONNECTOR & SOCKETS	.. 1
..	.. PLG80,90	.. ♦♦135 531	.. CONNECTOR & PINS	.. 1
..	.. PLG98	.. ♦♦131 056	.. CONNECTOR & SOCKETS	.. 1
.. 3	..	.. ♦♦115 443	.. STAND-OFF, 6-32 x .750 lg	.. 4
..	..	.. ♦♦♦138 542	.. SPOT/BURNBACK PREFLOW/POSTFLOW, RH	.. 1
..	..	.. ♦♦♦138 547	.. SPOT/BURNBACK PREFLOW/POSTFLOW, LH (consisting of)	.. 1
.. 4	..	.. 126 689	.. STAND-OFF, 6-32 x 1.500 lg	.. 2
.. 5	.. PC30	.. 188 834	.. CIRCUIT CARD, 4 in 1 timer	.. 1
..	.. PLG1,21,31	.. 115 092	.. CONNECTOR & SOCKETS	.. 3
..	.. PLG22,32	.. 135 409	.. CONNECTOR & PINS	.. 2
..	.. PLG35	.. 115 094	.. CONNECTOR & SOCKETS	.. 1
..	.. PLG90	.. 131 204	.. CONNECTOR & SOCKETS	.. 1
..	.. PLG91	.. 115 093	.. CONNECTOR & SOCKETS	.. 1
.. 6	..	.. 093 551	.. KNOB, pointer	.. 4
.. 7	..	.. 180 636	.. PLATE, control	.. 1
.. 8	..	.. 133 344	.. PANEL, option	.. 1
..	..	.. 120 304	.. BLANK, snap-in nyl .250mtg hole	.. 2
..	..	.. ♦♦♦194 679	.. RUN-IN CONTROL (consisting of)	.. 1
..	..	.. 153 037	.. SWITCH, reed	.. 1
..	..	.. 079 878	.. HOUSING	.. 1
..	..	.. 079 535	.. TERMINAL	.. 1
..	..	.. 079 531	.. CLAMP	.. 1
..	..	.. 048 834	.. CLAMP	.. 1
.. 7	..	.. 180 636	.. PLATE, control	.. 1
.. 8	..	.. 133 344	.. PANEL, option	.. 1
.. 9	..	.. 197 153	.. SPACER, mtg pc board	.. 1

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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**Figure 8-4. Control Panel (Fig 8-2 Item 2) (Continued)**

.. 10	PC80	196 746	CIRCUIT CARD, run-in control	1
.. 11		093 551	KNOB, .125dia shaft w/.125 set screw	1
.....	PLG16,54,76,76	115 093	CONNECTOR & SOCKETS	4
.....	PLG71,78,88	115 094	CONNECTOR & SOCKETS	3
.....	PLG79,79,89,100	115 091	CONNECTOR & SOCKETS	4
.....	PLG80,90,RC100	135 531	CONNECTOR & PINS	3
.....	PLG98	131 056	CONNECTOR & SOCKETS	1
.....	RC70	048 282	RECEPTACLE & SOCKETS	1
.....		120 304	BLANK, snap-in nyl .250mtg hole	6
.. 7		180 635	PLATE, control	2

◆ Part of Optional 138 542 RH and 138 547 LH Spot/Burnback, Preflow/Postflow

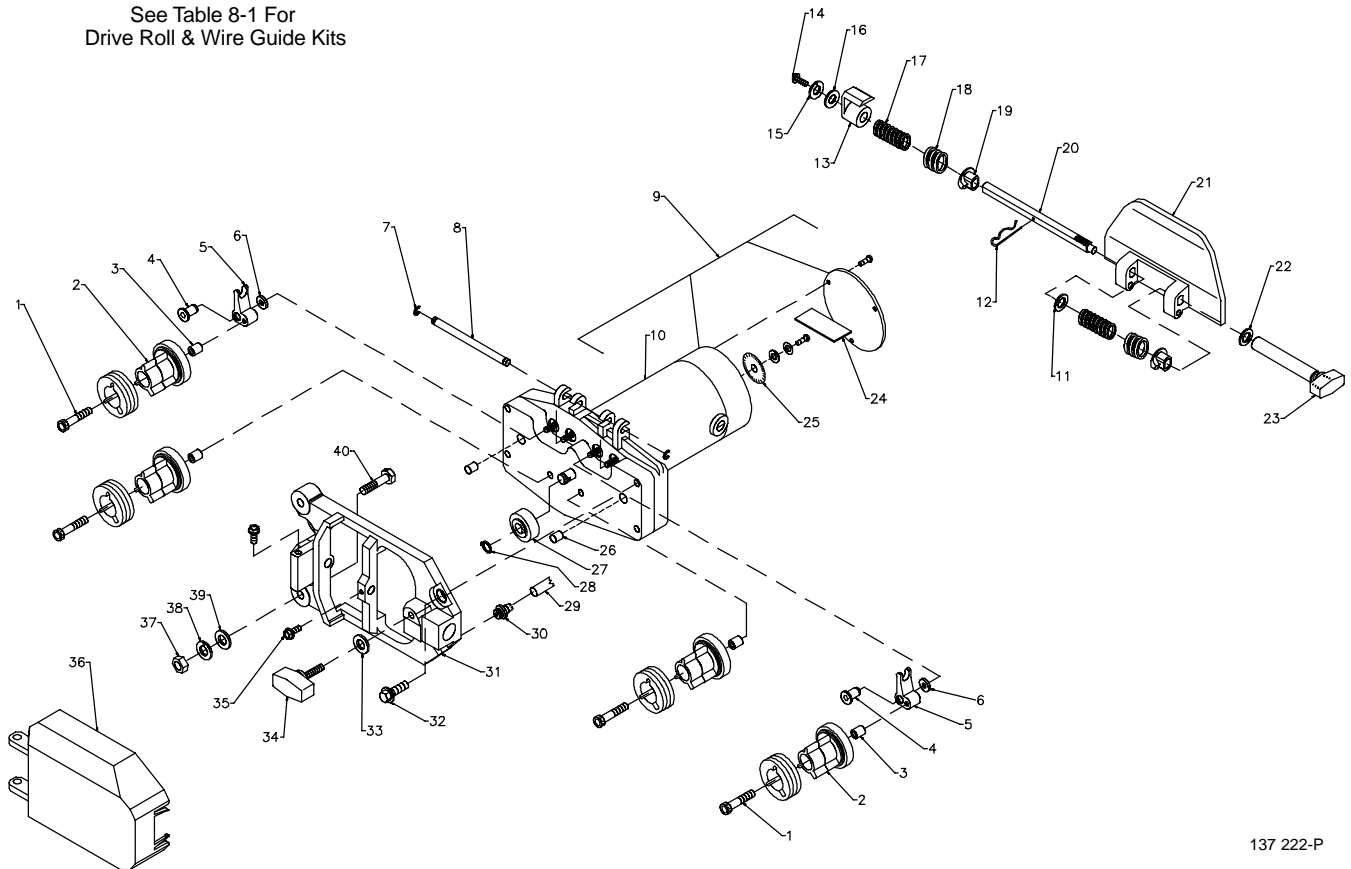
◆◆ Part of Optional 172 825 RH and 173 748 LH Digital Dual Schedule

◆◆◆ OPTIONAL

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

☞ Hardware is common and not available unless listed.

See Table 8-1 For Drive Roll & Wire Guide Kits



137 222-P

**Figure 8-5. Drive Assembly, Wire**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				2 Drive Roll	4 Drive Roll
<b>Figure 8-5. Drive Assembly, Wire (Fig 8-1 Items 15 &amp; 25)</b>					
...	1	010 668	.. SCREW, cap stl sch .250-20 x 1.500	2	4
...	2	172 075	.. CARRIER, drive roll w/components	2	4
...	3	149 962	.. SPACER, carrier drive roll	2	4
...	4	149 486	.. PIN, rotation arm rocker	1	2
...	5	132 750	.. ARM, pressure	1	2
...	6	150 520	.. SPACER, flat stl .257 ID x .619 OD x .105	1	2
...	7	133 493	.. RING, retaining ext .250 shaft x .025thk	2	2
...	8	133 350	.. PIN, hinge	1	1
...	9	M1 156 354	.. MOTOR, gear 1/8hp 24VDC 272RPM (consisting of)	1	1
...	9	M1 ♦ 156 353	.. MOTOR, gear 1/8hp 24VDC 500RPM (consisting of)	1	1
...		153 491	... KIT, brush replacement (consisting of)	1	1
...		153 492	... CAP, brush	2	2
...		*153 493	... BRUSH, carbon	2	2
...		184 136	... KIT, brush holder replacement	1	1
...	10	155 098	.. KIT, cover motor gearbox (consisting of)	1	1
...		153 550	.. COVER, motor gearbox (consisting of)	1	1
...		155 099	... GASKET, cover	1	1
...		155 100	... SCREW, cover	5	5
...		154 031	... SPACER, locating	2	2
...		133 493	... RING, rtng ext .250 shaft grv x .025thk	1	1
...	11	182 414	.. WASHER, flat	1	1
...	12	182 415	.. PIN, cotter hair	1	1
...	13	137 248	.. SPRING, indicator	1	1
...	14	602 082	.. SCREW, mach stl rdh 8-32 x .500	1	1
...	15	602 200	.. WASHER, lock stl split No. 8	1	1
...	16	604 772	.. WASHER, flat stl SAE No. 8	1	1
...	17	182 156	.. SPRING, cprsn	2	4
...	18	182 155	.. SPRING	1	2
...	19	132 746	.. BUSHING, spring	1	2
...	20	181 522	.. SHAFT, spring	1	1
...	21	132 747	.. CARRIER, shaft	1	1
...	22	133 739	.. WASHER, flat buna .375 ID x .625 OD x .062thk	1	1
...	23	183 330	.. KNOB, w/extension	1	1
...	24	PC51 ♦♦ 198 004	.. CIRCUIT CARD, digital tach (consisting of)	1	1
...		PLG57	... CONNECTOR & SOCKETS	1	1
...		604 311	... GROMMET, rbr .250 ID x .375mtg hole .062 groove	1	1
...		PLG58	... CONNECTOR & PINS	1	1
...	25	♦♦ 132 611	.. OPTICAL ENCODER DISC	1	1
...	26	167 387	.. SPACER, locating	2	2
...	27	168 825	.. DRIVE, pinion	1	1
...	28	133 308	.. RING, retaining ext .375 shaft x .025thk	1	1
...	29	134 834	.. HOSE, SAE .187 ID x .410 OD (order by ft)	2ft	2ft
...	30	149 959	.. FITTING, brs barbed M 3/16tbg x .312-24	1	1
...	31	179 265	.. ADAPTER, gun/feeder LH	1	1
...	31	179 264	.. ADAPTER, gun/feeder RH	1	1
...	32	108 940	.. SCREW, cap stl hexhd .250-20 x .750	4	4
...	33	604 538	.. WASHER, flat stl SAE .312	1	1
...	34	151 437	.. KNOB, plstc T 1.125 lg x .312-18 x 1.500	1	1
...	35	151 290	.. SCREW, mach stl hexwhd 10-32 x .500	2	2
...	36	179 277	.. COVER, drive roll (consisting of)	1	1
...		178 937	... LABEL, warning electric shock	1	1
...	37	601 872	.. NUT, stl hex full fsh .375-16	1	1
...	38	602 213	.. WASHER, lock stl split .375	1	1
...	39	602 243	.. WASHER, flat stl std .375	1	1
...	40	601 966	.. SCREW, cap stl hexhd .375-16 x 1.250	1	1

♦ Optional High Speed Motor

\*Recommended Spare Parts.

♦♦ Part of Optional Tach

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

Table 8-1. Drive Roll And Wire Guide Kits

Wire Size	Inlet Guide	Intermediate Guide	V-GROOVE			U-GROOVE			VK-GROOVE			UC-GROOVE					
			2 Roll Kit	4 Roll Kit	Drive Roll	2 Roll Kit	4 Roll Kit	Drive Roll	2 Roll Kit	4 Roll Kit	Drive Roll	2 Roll Kit	4 Roll Kit	Drive Roll			
.023-.025 in.	150 993	149 518	151 030	151 024	087 130												
.030 in.	150 993	149 518	151 031	151 025	053 695												
.035 in.	150 993	149 518	151 032	151 026	053 700	151 044	151 036	072 000	151 061	151 052	132 958						
.040 in.	150 993	149 518	161 189	161 190													
.045 in.	150 994	149 519	151 033	151 027	053 697	151 045	151 037	053 701	151 062	151 053	132 957			151 077	151 070	083 489	
.052 in.	150 994	149 519	151 034	151 028	053 698	151 046	151 038	053 702	151 063	151 054	132 956			151 078	151 071	083 490	
1/16 in. (.062 in.)	150 995	149 520	151 035	151 029	053 699	151 047	151 039	053 706	151 064	151 055	132 955			151 079	151 072	053 708	
.068-.072 in.	150 995	149 520							151 065	151 056	132 959						
5/64 in. (.079 in.)	150 995	149 520				151 048	151 040	053 704	151 066	151 057	132 960			151 080	151 073	053 710	
3/32 in. (.094 in.)	150 996	149 521				151 049	151 041	053 703	151 067	151 058	132 961			151 081	151 074	053 709	
7/64 in. (.110 in.)	150 996	149 521				151 050	151 042	053 705	151 068	151 059	132 962			151 082	151 075	053 711	
1/8 in. (.125 in.)	150 997	149 522				151 051	151 043	053 707	151 069	151 060	132 963			151 083	151 076	053 712	

Each Kit Contains An Inlet Guide, Intermediate Guide, And 045 233 Antiwear Guide w/604 612 Setscrew 8-32 x .125, along with 2 Or 4 Drive Rolls  
2 Kits Required for D-62 & D-64

S-0527-C



# TRUE BLUE<sup>®</sup>

## WARRANTY

Effective January 1, 2000

(Equipment with a serial number preface of "LA" or newer)

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

### Warranty Questions?

Call  
1-800-4-A-MILLER  
for your local  
Miller distributor.

Your distributor also gives  
you ...

#### Service

You always get the fast,  
reliable response you  
need. Most replacement  
parts can be in your  
hands in 24 hours.

#### Support

Need fast answers to the  
tough welding questions?  
Contact your distributor.  
The expertise of the  
distributor and Miller is  
there to help you, every  
step of the way.

**LIMITED WARRANTY** – Subject to the terms and conditions below, Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed.

Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the date that the equipment was delivered to the original retail purchaser, or one year after the equipment is sent to a North American distributor or eighteen months after the equipment is sent to an International distributor.

1. 5 Years Parts – 3 Years Labor
  - \* Original main power rectifiers
  - \* Inverters (input and output rectifiers only)
2. 3 Years — Parts and Labor
  - \* Transformer/Rectifier Power Sources
  - \* Plasma Arc Cutting Power Sources
  - \* Semi-Automatic and Automatic Wire Feeders
  - \* Inverter Power Supplies
  - \* Intelligig
  - \* Engine Driven Welding Generators  
**(NOTE: Engines are warranted separately by the engine manufacturer.)**
3. 1 Year — Parts and Labor
  - \* DS-2 Wire Feeder
  - \* Motor Driven Guns (w/exception of Spoolmate 185 & Spoolmate 250)
  - \* Process Controllers
  - \* Positioners and Controllers
  - \* Automatic Motion Devices
  - \* RFCS Foot Controls
  - \* Induction Heating Power Sources
  - \* Water Coolant Systems
  - \* HF Units
  - \* Grids
  - \* Maxstar 140
  - \* Spot Welders
  - \* Load Banks
  - \* Miller Cyclomatic Equipment
  - \* Running Gear/Trailers
  - \* Plasma Cutting Torches (except APT & SAF Models)
  - \* Field Options  
**(NOTE: Field options are covered under True Blue<sup>®</sup> for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)**
4. 6 Months — Batteries
5. 90 Days — Parts
  - \* MIG Guns/TIG Torches
  - \* Induction Heating Coils and Blankets

- \* APT, ZIPCUT & PLAZCUT Model Plasma Cutting Torches
- \* Remote Controls
- \* Accessory Kits
- \* Replacement Parts (No labor)
- \* Spoolmate 185 & Spoolmate 250
- \* Canvas Covers

Miller's True Blue<sup>®</sup> Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, slip rings, relays or parts that fail due to normal wear.**
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

MILLER PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Miller's option: (1) repair; or (2) replacement; or, where authorized in writing by Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense. Miller's option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Miller authorized service facility as determined by Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

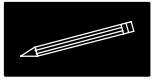
TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

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Some states in the U.S.A. do not allow limitations of how long an implied warranty lasts, or the exclusion of incidental, indirect, special or consequential damages, so the above limitation or exclusion may not apply to you. This warranty provides specific legal rights, and other rights may be available, but may vary from state to state.

In Canada, legislation in some provinces provides for certain additional warranties or remedies other than as stated herein, and to the extent that they may not be waived, the limitations and exclusions set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary from province to province.





# Owner's Record

Please complete and retain with your personal records.

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Model Name	Serial/Style Number
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Purchase Date	(Date which equipment was delivered to original customer.)
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Distributor	
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Address	
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City	
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State	Zip
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## For Service

**Call 1-800-4-A-Miller or see our website at [www.MillerWelds.com](http://www.MillerWelds.com) to locate a DISTRIBUTOR or SERVICE AGENCY near you.**

Always provide Model Name and Serial/Style Number.

- 
- |                               |   |
|-------------------------------|---|
| Contact your Distributor for: | Welding Supplies and Consumables                    |
|                               | Options and Accessories                             |
|                               | Personal Safety Equipment                           |
|                               | Service and Repair                                  |
|                               | Replacement Parts                                   |
|                               | Training (Schools, Videos, Books)                   |
|                               | Technical Manuals (Servicing Information and Parts) |
|                               | Circuit Diagrams                                    |
|                               | Welding Process Handbooks                           |

Contact the Delivering Carrier for: File a claim for loss or damage during shipment.

For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.

### Miller Electric Mfg. Co.

An Illinois Tool Works Company  
1635 West Spencer Street  
Appleton, WI 54914 USA

### International Headquarters—USA

USA Phone: 920-735-4505 Auto-Attended  
USA & Canada FAX: 920-735-4134  
International FAX: 920-735-4125

### European Headquarters – United Kingdom

Phone: 44 (0) 1204-593493  
FAX: 44 (0) 1204-598066

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